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(54) Title: HAIR COLORING COMPOSITIONS				
(57) Abstract				
<p>A hair coloring composition comprising: (a) a water-soluble peroxygen bleach; (b) a bleaching aid selected from organic peroxyacid bleach precursors and/or preformed organic peroxyacids; (c) one or more hair coloring agents. The products can provide excellent hair coloring and in-use efficacy benefits including excellent initial color and good wash fastness in combination with reduced hair damage at lower pH.</p>				

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## Hair Coloring Compositions

### Technical Field

This invention relates to hair coloring compositions and processes for coloring hair, and more especially to hair coloring compositions comprising a source of hydrogen peroxide and a bleaching aid selected from organic peroxyacid bleach precursors and/or preformed organic peroxyacids in combination with one or more hair coloring agents.

### Background of the Invention

The primary colored component of human or animal hair is melanin pigment. Melanin occurs naturally within the hair cortex in 'granular' form.

To successfully color human or animal hair it is generally necessary to decolorize the hair prior to the application of the coloring agent(s) of choice. This decolorization process is generally referred to as hair bleaching. The objective of hair bleaching compositions is to selectively decolorize both the naturally occurring melanin pigment in hair and in addition any synthetic pigments previously applied to the hair with minimal damage to the hair structure. When hair is bleached, the color changes to lighter and lighter shades depending upon the amount of melanin oxidised and removed from the hair in the decoloring process.

Bleaching compositions used on hair differ from those used with textiles, fabrics, hard surface cleansing and the like, such as sodium hypochlorite, in that hair bleaching compositions, in addition to oxidising and destroying the colored melanin of the hair, must be suitable for use in contact with the human skin and must not damage the hair excessively. Furthermore, since hair bleaches are a member of the class of materials known as cosmetics, it is

desirable that they be aesthetically acceptable to the user. Finally, it is desirable that a hair bleaching composition remove the melanin coloration from the hair as quickly as possible for the sake of convenience and to help prevent untoward damage to the hair and irritation to the skin and scalp.

Hydrogen peroxide is the most commonly used hair bleaching / melanin oxidising agent. However, hydrogen peroxide treatment of the hair not only solubilises the melanin but can also lead to undesirable hair qualities, such as increased brittleness, and to hair damage, which are in part due to the preferred conditions of conventional peroxide treatment which requires high pH (> pH 9), extended exposure (from 20 to 90 minutes) and relatively high concentration of bleaching solutions (up to 30% volume of oxygen) in order to deliver effective bleaching.

Hair bleaching and coloring compositions commonly contain a source of peroxide, bleach activating agents and a variety of additional cosmetic and bleach stabilising agents. Peroxide bleaches must be 'activated' to effect hair bleaching, this typically being accomplished by the use of an 'activating agent' to adjust the pH of the bleaching solution accordingly. The activating material for adjusting the pH of peroxide hair bleaching compositions is an aqueous (alkaline) solution containing ammonia (ammonium hydroxide). A variety of alternative pH adjusting agents to ammonia have also been proposed.

In addition, certain 'activator' materials may also act as hair swelling agents (HSA's). Such HSA's further enhance the bleaching and coloring process by swelling the hair fibres to aid both the diffusion of the peroxide and coloring agents into the hair and enabling faster, more thorough bleaching (solubilisation /decolorisation of the hair melanin) and subsequent coloring. Ammonia is a particularly effective HSA. However ammonia can cause skin irritation when used at levels of about 1% by weight of composition or higher.

Persulphate type bleaches have been proposed in the hair care area as alternative bleaching systems. However persulphate is a less effective bleach

versus conventional peroxide bleaches, requiring higher concentration and longer exposure to effect an equivalent degree of bleaching to conventional bleach.

Neither ammonia-activated, nor alternatively activated bleaching and coloring systems comprising conventional bleaching agents or alternative bleaches such as persulphate to date have been able to fully satisfy the desire for effective bleaching and desirable hair coloring in a speedy time with minimal hair damage and at lower pH. Thus a need exists for hair coloring compositions which can deliver effective hair bleaching at lower pH values, impart reduced hair damage, excellent color attributes and which have low impact on the skin.

Applicant has now found that hair coloring compositions comprising the combination of conventional peroxide oxidising agents with certain bleaching aids and one or more coloring agents can deliver excellent hair coloring over time in combination with reduced hair damage at a lower pH and in a faster time. Furthermore, applicant has found that the combination of certain bleaching aids with a source of peroxide at particular levels and ratios in the coloring compositions of the present invention can deliver excellent hair coloring results, minimal hair damage, are effective at lower pH and can work in a faster time.

Thus it is an object of the present invention to provide fast acting hair coloring compositions.

It is a further object of the present invention to provide hair coloring compositions which deliver improved hair coloring.

It is a still further object of the present invention to provide hair coloring compositions which are effective at lower pH.

It is an additional object of the present invention to provide hair coloring compositions which impart minimal damage to the hair fibres.

All percentages are by weight of the compositions unless specified otherwise.

### Summary of the Invention

The subject of the present invention is a hair coloring composition suitable for the treatment of human or animal hair, comprising:

- (a) a water-soluble peroxygen bleach;
- (b) a bleaching aid selected from organic peroxyacid bleach precursors and/or preformed organic peroxyacids; and
- (c) one or more hair coloring agents

### Detailed Description of the Invention

As used herein the term 'hair' to be treated may be 'living' i.e. on a living body or may be 'non-living' i.e. in a wig, hairpiece or other aggregation of non-living fibres. Mammalian, preferably human hair is preferred. However wool, fur and other melanin containing fibres are suitable substrates for the compositions according to the present invention.

As used herein the term 'hair coloring composition' is used in the broad sense in that it is intended to encompass the combinations herein of peroxide, bleaching aid and coloring agents as well as other ingredients. Moreover, it is also intended to include complex compositions which contain other components which may or may not be active ingredients. Thus, the term 'hair coloring composition' is intended to apply to compositions which contain, in addition to a mixture of active oxidising or bleaching agents and coloring agents such things as, by way of example, sequestrants, thickeners, buffers, carriers, surfactants, surface active agents, solvents, alkalisng agents, antioxidants, polymers and conditioners.

As discussed above, the hair coloring compositions according to the present invention comprise water soluble peroxygen bleach in combination with a bleaching aid selected from organic peroxyacid bleach precursors and/or preformed organic peroxyacids as well as one or more hair coloring agents. Bleaching aid, as used herein is to be regarded as interchangeable with the commonly used term 'bleach accelerator'. Bleach precursor as used herein is intended to cover any organic peroxy based material which can act in combination with a source of peroxide to deliver enhanced hair bleaching.

The amount of peroxygen bleach and peroxyacid bleaching aid component in the preferred compositions of the present invention may be expressed both in terms of weight or molar ratios' and/or available oxygen' (AO).

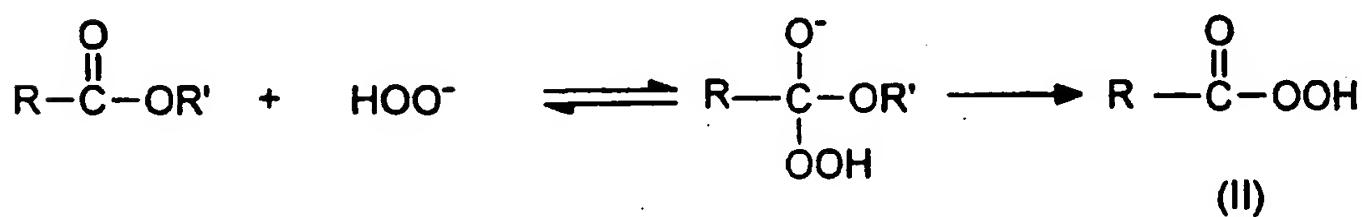
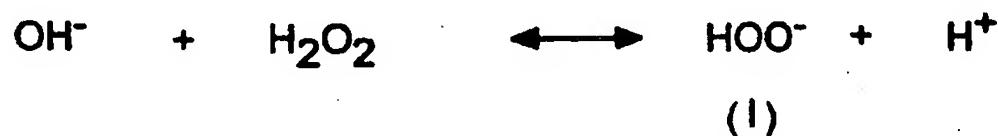
In general, the weight ratio of peroxygen bleach to bleaching aid such as organic peroxyacid precursor is in the range of from about 20:1 to about 1:20, more preferably from about 10:1 to about 1:10 and especially from about 5:1 to about 1:5. These weight ratios correspond, in general, to molar ratios in the range of from about 400:1 to about 1:5, preferably from about 200:1 to about 1:2 and especially from about 3:1 to about 10:1.

The term 'available oxygen', as further defined in the Example section herein, is the theoretical amount of oxygen that can be delivered to the system from the organic peroxyacid precursor and/or the peroxide material. In preferred compositions the total level of available oxygen from the organic peroxyacid precursor and the peroxide components is from about 0.5 to about 60, preferably from about 2 to about 55 and especially from about 3 to about 50. In highly preferred compositions containing hydrogen peroxide and nonanoyl oxybenzenesulphonate (NOBS) the ratio of AO from the peroxide to NOBS component is in the ratio of from about 8 : 1 to about 12 : 1.

#### The Hair Bleaching and Coloring Process

It is understood by those familiar in the art that to successfully color human or animal hair it is generally necessary to decolorize the hair prior to the application of the coloring agent(s) of choice. This decolorization process is generally referred to as hair bleaching. As herein before described such bleaching is commonly effected via the use of oxidising agents. It is further understood by those familiar in the art that hair bleaching via use of oxidising agents is a two-step process. Firstly the colored melanin pigment in the hair is solubilised and secondly the solubilised melanin pigment is decolored. It is further understood that in hydrogen peroxide based bleaching systems the reaction between melano-protein and hydrogen peroxide is confined to the mainly protein-combined cystein residues which are subsequently converted to combined cysteic acid. The solubilisation of the melanin pigment is connected with the splitting of the disulphide bridges in the melano protein and it is likely that the disulfide bridge may be the stabilising factor in melanin, as it is in keratins.

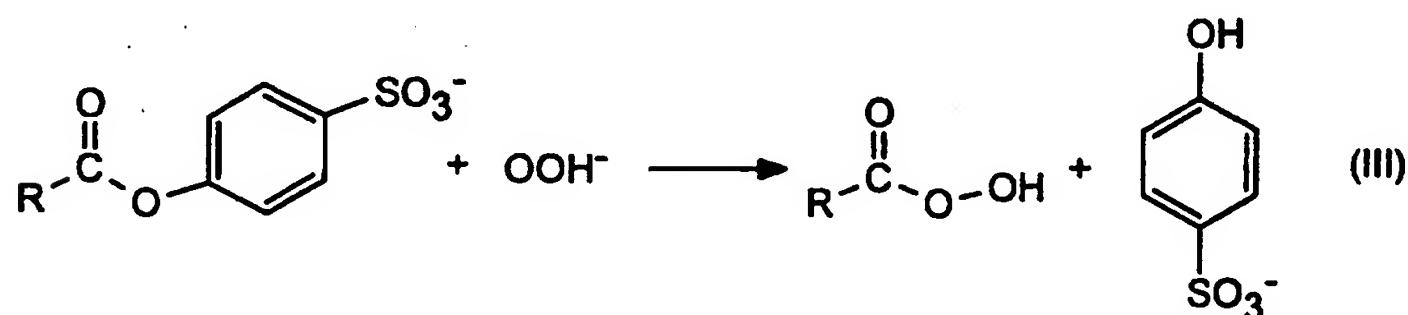
The mechanism by which peroxyacid precursor bleaching aids react with peroxygen bleaching agents to generate bleaching compounds in general, and by which hair is subsequently bleached, in particular, is not completely understood. However, it is generally believed that the peroxyacid bleach precursor undergoes nucleophilic attack by a perhydroxyl anion (I), which is generated from deprotonation of the hydrogen peroxide, to form a peroxycarboxylic acid (II). This reaction is commonly referred to as perhydrolysis. A general representation of the perhydrolysis process is illustrated below:

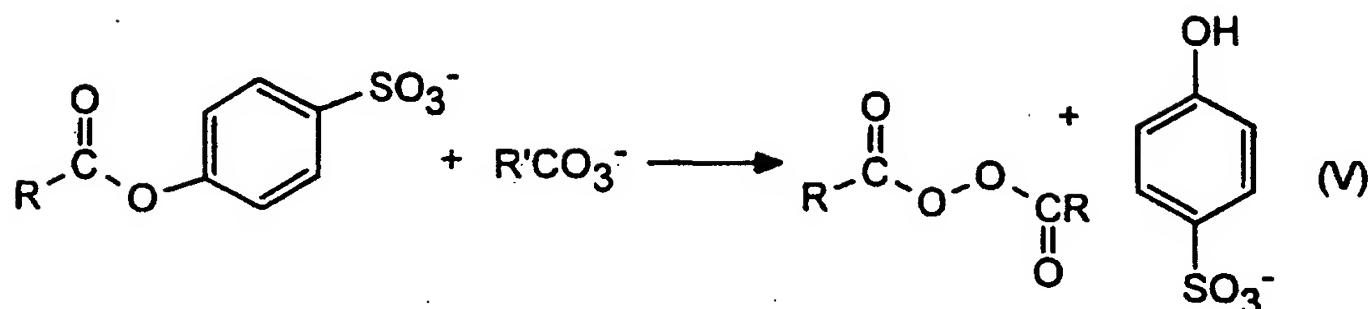
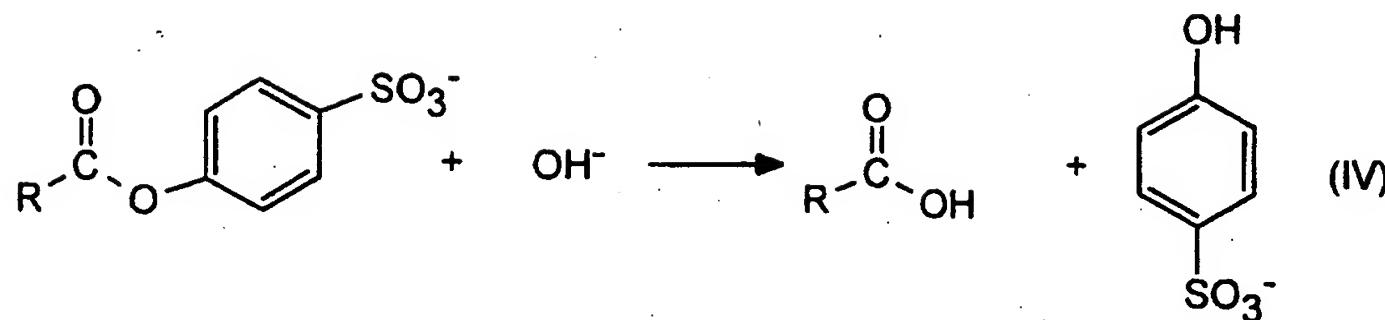


In the above examples R can be an alkyl or aryl group and R' is any suitable leaving group. Suitable examples of R and R' are discussed under the heading Peroxyacid bleach precursor herein. As generation of the perhydroxyl anion (I) from hydrogen peroxide is the initiating step in the perhydrolysis process, the maintenance of optimum reaction conditions to promote this conversion is key. Hydrogen peroxide has a pKa in the range of from about 11.2 to about 11.6, and, as such is generally most effective as a bleaching agent at pHs in the range of from about 9 to about 12. In contrast the pKas of the peroxyacid bleach precursors of the present invention are in the range of from about 7 to about 9.5.

Applicant has found that when the organic peroxyacid bleach precursors and/or preformed peroxyacids of the present invention are used in combination with a source of peroxide to facilitate the perhydrolysis reaction excellent melanin solubilisation and decoloration can be achieved with hair bleaching solutions over a wide range of solution pH of from about 6 to about 12, preferably between about 7 to about 10.5. Such pH values can be maintained by use of substances commonly known as buffering agents, which are optional components of the hair coloring compositions herein.

The perhydrolysis of the nonoyl oxybenzene sulphonate (NOBS) peroxyacid bleach activator is illustrated by (III) below. Concurrent competitive side reactions which can impact bleach efficacy are hydrolysis and formation of diacylperoxide (DAP) as illustrated by (IV) and (V) below:





### Peroxygen Bleaches

The compositions of the invention comprise as an essential feature at least one water-soluble peroxygen bleach compound. Water soluble as defined herein means a bleach compound which can be substantially solubilised in water. Such peroxygen bleaching materials are valuable for the initial solubilisation and decolorisation of the melanin in the hair substrate.

The peroxygen bleaching compounds useful herein are generally inorganic peroxygen bleaches capable of yielding hydrogen peroxide in an aqueous solution. Water-soluble peroxygen bleaching compounds are well known in the art and include hydrogen peroxide, inorganic alkali metal peroxides such as sodium periodate and sodium peroxide and organic peroxides such as urea peroxide, melamine peroxide, and inorganic perhydrate salt bleaching compounds, such as the alkali metal salts of perborates, percarbonates, perphosphates, persilicates, persulphates and the like. These inorganic perhydrate salts may be incorporated as monohydrates, tetrahydrates etc. Mixtures of two or more such bleaching compounds can be used if desired. Preferred for use in the compositions according to the present invention is hydrogen peroxide.

The peroxygen bleaching compound is present in the compositions of the present invention at a level of from about 0.5% to about 40%, preferably from about 1% to about 20%, more preferably from about 1.5% to about 7% by weight.

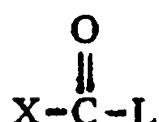
### Bleaching Aid

As a further essential feature the compositions of the present invention comprise a bleaching aid selected from peroxyacid bleach precursors and/or preformed organic peroxyacid bleach precursors. These peroxy materials are valuable for the enhanced bleaching of the hair in a faster time and at lower pH. While not wishing to be bound by any particular theory it is believed that the peroxyacid bleach precursors of the present invention enhance the bleaching process by acting as bleach activators to facilitate more efficient bleaching.

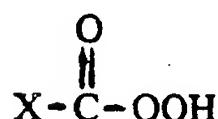
Bleaching aids are preferably incorporated at a level of from 0.5% to 40% by weight, more preferably from 1% to 20% by weight, most preferably from 1.5% to 7% by weight of the hair bleaching compositions.

### Peroxyacid Bleach Precursors

Peroxyacid bleach precursors are compounds which react with hydrogen peroxide in a perhydrolysis reaction to produce a peroxyacid. Generally peroxyacid bleach precursors may be represented as:



where L is a leaving group and X is essentially any functionality which can facilitate the perhydrolysis reaction and is a poorer leaving group than L, such that upon perhydrolysis the structure of the peroxyacid produced is:

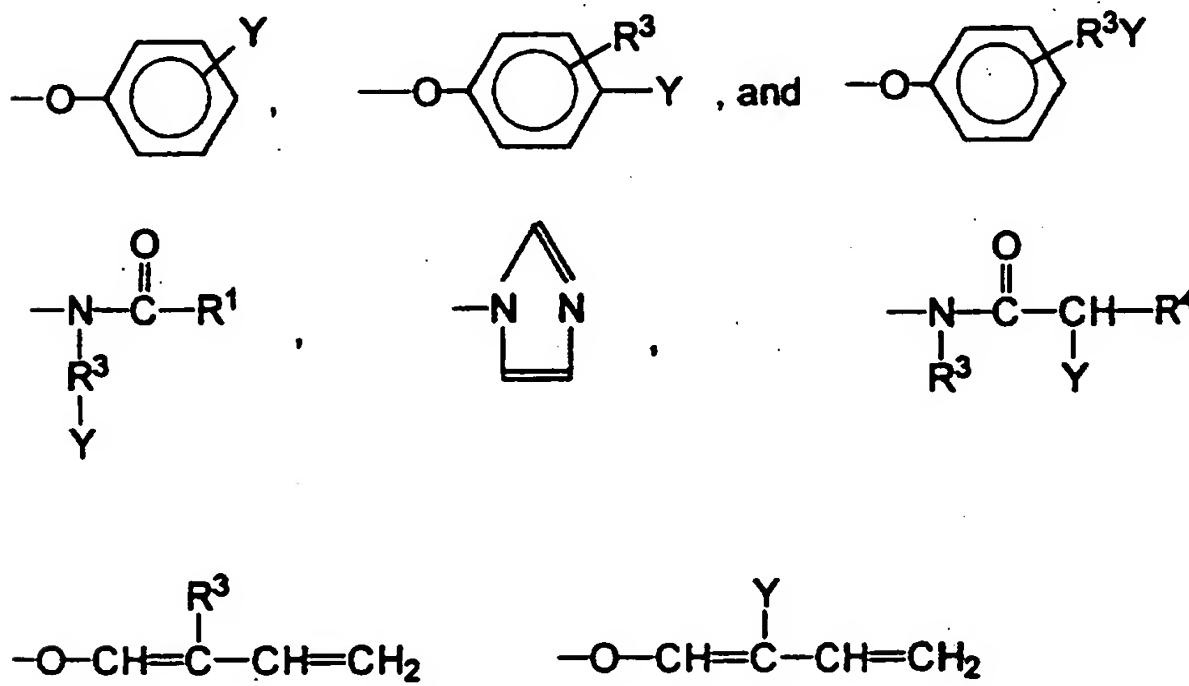


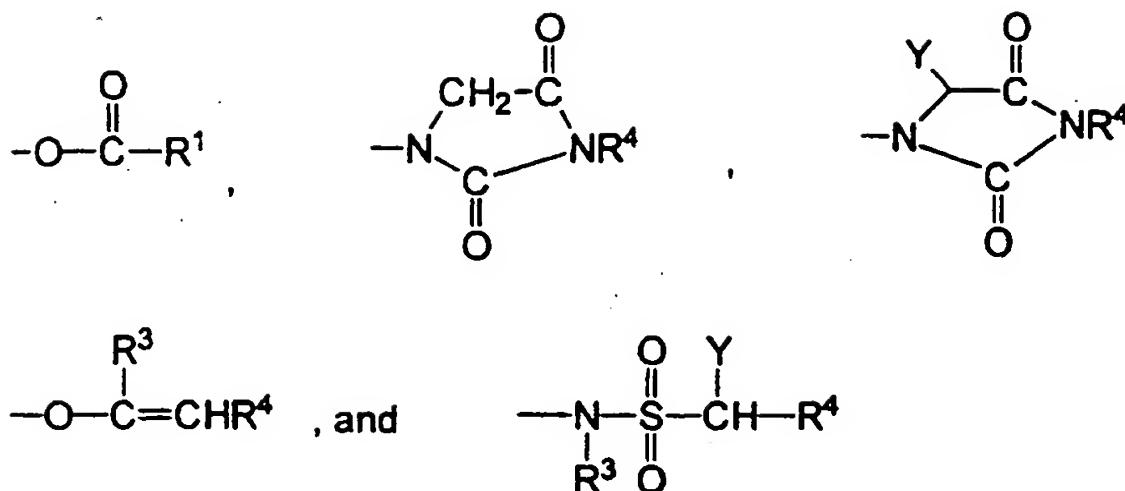
Suitable peroxyacid bleach precursor compounds typically contain one or more N- or O-acyl groups in the L position, which precursors can be selected from a wide range of classes. Suitable classes include anhydrides, esters, imides, lactams, enol ethers, sulphonic ester amides and acylated derivatives of imidazoles and oximes. Examples of useful materials within these classes are disclosed in GB-A-1586789. Suitable esters are disclosed in GB-A-836988, 864798, 1147871, 2143231 and EP-A-0170386.

### Leaving groups

The leaving group, hereinafter L group, must be sufficiently reactive for the perhydrolysis reaction to occur within the desired time frame (e.g., from 0 to 20 minutes, preferably from 0 to 10 minutes, more preferably from 1 to 5 minutes time exposure).

Preferred L groups are selected from the group consisting of:





and mixtures thereof, wherein  $R^1$  is an alkyl, aryl, or alkaryl group containing from 1 to 14 carbon atoms,  $R^3$  is an alkyl chain containing from 1 to 8 carbon atoms,  $R^4$  is H or  $R^3$ , and Y is H or a solubilizing group wherein the solubilizing group is any suitable hydrophilic group capable of enhancing the water solubility of the L group. Any of  $R^1$ ,  $R^3$  and  $R^4$  may be substituted by essentially any functional group including, for example alkyl, hydroxy, alkoxy, halogen, amine, nitrosyl, amide and ammonium or alkyl ammonium groups

The preferred solubilizing groups are  $-SO_3^{2-}M^+$ ,  $-CO_3^{2-}M^+$ ,  $-SO_4^{2-}M^+$ ,  $-N^+(R^3)_4X^-$  and  $O<-N(R^3)_3$  and most preferably  $-SO_3^{2-}M^+$  and  $-CO_3^{2-}M^+$  wherein  $R^3$  is an alkyl chain containing from 1 to 4 carbon atoms, M is a cation which provides solubility to the bleach precursor and X is an anion which provides solubility to the bleach precursor. Preferably, M is an alkali metal, ammonium or substituted ammonium cation, with sodium and potassium being most preferred, and X is a halide, hydroxide, methylsulfate or acetate anion.

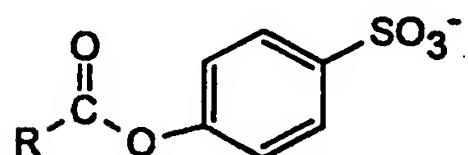
A wide variety of bleach precursors are suitable for use in the compositions according to the present invention. These include alkyl percarboxylic acid precursors, amide substituted alkyl peroxyacid precursors, perbenzoic acid precursors, cationic peroxyacid precursors, benzoxazin organic peroxyacid precursors.

### Alkyl percarboxylic acid bleach precursors

Alkyl percarboxylic acid bleach precursors form percarboxylic acids on perhydrolysis. Preferred precursors of this type provide peracetic acid on perhydrolysis. Any substituted or unsubstituted alkyl group having on average from 1 to 20 carbon atoms is suitable for use in the alkyl percarboxylic acid bleach precursors herein.

Preferred alkyl percarboxylic precursor compounds of the imide type include the N-,N,N<sup>1</sup>N<sup>1</sup> tetra acetylated alkylene diamines wherein the alkylene group contains from 1 to 6 carbon atoms, particularly those compounds in which the alkylene group contains 1, 2 and 6 carbon atoms. Tetraacetyl ethylene diamine (TAED) is particularly preferred.

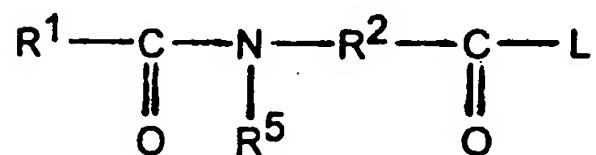
Other preferred alkyl percarboxylic acid precursors include sodium 3,5,5-trimethyl hexanonanoyloxybenzene sulfonate (iso-NOBS), sodium nonanoyloxybenzene sulfonate (NOBS), sodium acetoxybenzene sulfonate (ABS) and pentaacetyl glucose. Sodium nonanoyloxybenzene sulfonate is illustrated below:



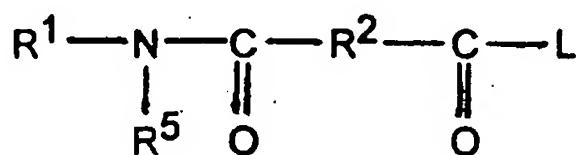
In the above example R = C<sub>8</sub>H<sub>17</sub> wherein X = C<sub>8</sub>H<sub>17</sub> and L = O-C<sub>6</sub>H<sub>4</sub>-SO<sub>3</sub><sup>-</sup>

### Amide substituted alkyl peroxyacid bleach precursors

Amide substituted alkyl peroxyacid precursor compounds are suitable herein, including those of the following general formulae:



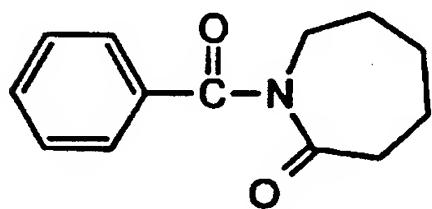
or



wherein R<sup>1</sup> is an alkyl group with from 1 to 14 carbon atoms, R<sup>2</sup> is an alkylene group containing from 1 to 14 carbon atoms, and R<sup>5</sup> is H or an alkyl group containing 1 to 10 carbon atoms and L can be essentially any leaving group. Amide substituted bleach activator compounds of this type are described in EP-A-0170386.

#### Perbenzoic acid bleach precursor

Perbenzoic acid precursor compounds provide perbenzoic acid on perhydrolysis. Suitable O-acylated perbenzoic acid precursor compounds include the substituted and unsubstituted benzoyl oxybenzene sulfonates, and the benzoylation products of sorbitol, glucose, and other saccharides with benzoylating agents, and those of the imide type including N-benzoyl succinimide, tetrabenzoyl ethylene diamine and the N-benzoyl substituted ureas. Suitable imidazole type perbenzoic acid precursors include N-benzoyl imidazole, N-benzoyl caprolactam and N-benzoyl benzimidazole. Other useful N-acyl group-containing perbenzoic acid precursors include N-benzoyl pyrrolidone, dibenzoyl taurine and benzoyl pyroglutamic acid. The example below illustrates N-benzoyl caprolactam:



#### Cationic peroxyacid bleach precursors

Cationic peroxyacid precursor compounds produce cationic peroxyacids on perhydrolysis.

Typically, cationic peroxyacid precursors are formed by substituting the peroxyacid part of a suitable peroxyacid precursor compound with a positively charged functional group, such as an ammonium or alkyl

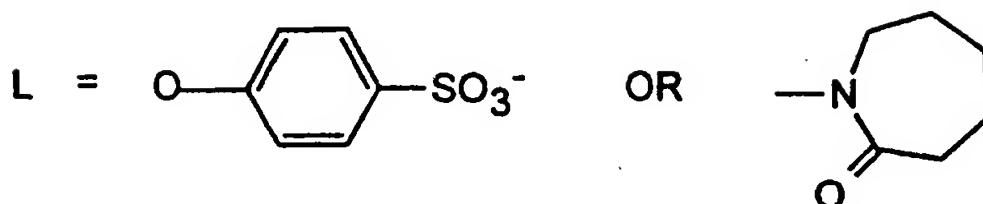
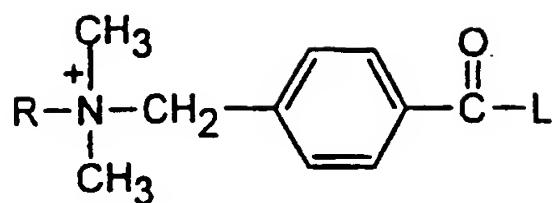
ammonium group, preferably an ethyl or methyl ammonium group. Cationic peroxyacid precursors are typically present in the compositions herein as a salt with a suitable anion, such as a halide ion.

The peroxyacid precursor compound to be so cationically substituted may be a perbenzoic acid, or substituted derivative thereof, precursor compound as described herein before. Alternatively, the peroxyacid precursor compound may be an alkyl percarboxylic acid precursor compound or an amide substituted alkyl peroxyacid precursor as described hereinafter

Cationic peroxyacid precursors are described in US Patents 4,904,406; 4,751,015; 4,988,451; 4,397,757; 5,269,962; 5,127,852; 5,093,022; 5,106,528; GB-A-1,382,594; EP-A-0,475,512, EP-A-0,458,396 and EP-A-0,284,292; and in JP-A-87-318,332.

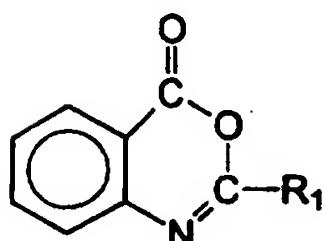
Examples of preferred cationic peroxyacid precursors are described in GB-A-9407944.9 and US-A-08/298903; 08/298650; 08/298904 and 08/298906.

Suitable cationic peroxyacid precursors include any of the ammonium or alkyl ammonium substituted alkyl or benzoyl oxybenzene sulfonates, N-acylated caprolactams, and monobenzoyltetraacetyl glucose benzoyl peroxides. Preferred cationic peroxyacid precursors of the N-acylated caprolactam class include the trialkyl ammonium methylene benzoyl caprolactams and the trialkyl ammonium methylene alkyl caprolactams. Illustrated below are examples of an alkyl ammonium substituted benzoyl oxybenzene sulfonate and a trialkyl ammonium methylene benzoyl caprolactam:



#### Benzoxazin organic peroxyacid bleach precursors

Also suitable are precursor compounds of the benzoxazin-type, as disclosed for example in EP-A-332,294 and EP-A-482,807, particularly those having the formula:

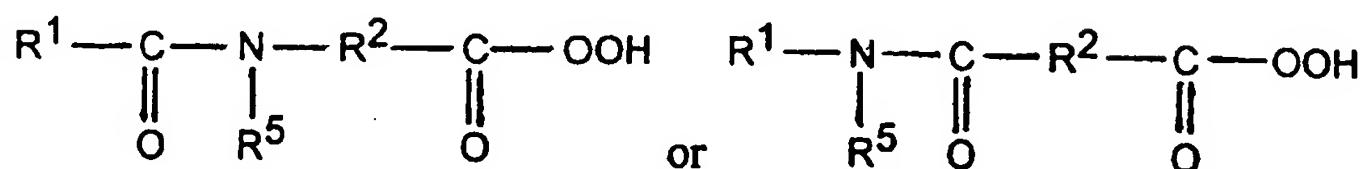


wherein  $\text{R}_1$  is H, alkyl, alkaryl, aryl, or arylalkyl.

#### Preformed organic peroxyacid

The preformed organic peroxyacids of the present invention are typically present at a level of from about 0.1% to about 15% by weight, more preferably from about 0.5% to about 10% and especially from about 0.5% to about 5% by weight of the composition.

A preferred class of organic peroxyacid compounds are the amide substituted compounds of the following general formulae:



wherein  $\text{R}^1$  is an alkyl, aryl or alkaryl group with from 1 to 14 carbon atoms,  $\text{R}^2$  is an alkylene, arylene, and alkarylene group containing from 1 to 14 carbon atoms, and  $\text{R}^5$  is H or an alkyl, aryl, or alkaryl group containing 1 to 10 carbon atoms. Amide substituted organic peroxyacid compounds of this type are described in EP-A-0,170,386.

Other organic peroxyacids include peracetic, pernanoic, nonylamidoperoxycaproic acid (NAPCA), diacyl and tetraacylperoxides, especially diperoxydodecanedioic acid, diperoxytetradecanedioic acid and diperoxyhexadecanedioic acid. Mono- and diperazelaic acid, mono- and diperbrassylic acid and N-phthaloylaminoperoxycaproic acid are also suitable herein.

The preferred peroxyacid materials for use herein are selected from acetyl triethylcitrate (ATC), tetraacetyl ethylene diamine (TAED, nonanoyl oxybenzenesulphonate (NOBS), (6-octaamidocaproyl) oxybenzene sulphonate and (6-decaamindocaproyl) oxybenzene sulphate and peracetic and pernanoic acids and mixtures thereof. In highly preferred compositions the peroxy acid material is selected from acetyl triethylcitrate (ATC), tetraacetyl ethylene diamine (TAED), nonanoyl oxybenzenesulphonate (NOBS), (6-octaamidocaproyl) oxybenzene sulphonate and (6-decaamindocaproyl) oxybenzene sulphate and mixtures thereof

### Buffering Agents

The coloring compositions of the present invention have a preferred pH in the range of from about 6 to about 12, more preferably from about 7 to about 10.5.

As herein before described the preferred coloring compositions of the present invention may contain one or more buffering agents to adjust the pH to the desired level. Several different pH modifiers can be used to adjust the pH of the final composition or any constituent part thereof.

This pH adjustment can be effected by using well known acidifying agents in the field of treating keratinous fibres, and in particular human hair, such as inorganic and organic acids such as hydrochloric acid, tartaric acid, citric acid, phosphoric acid and carboxylic or sulphonic acids such as ascorbic acid, acetic acid, lactic acid, sulphuric acid, formic acid, ammonium sulphate and sodium dihydrogenphosphate /phosphoric acid, disodium hydrogenphosphate /phosphoric acid, potassium chloride /hydrochloric acid, potassium dihydrogen phthalate/ hydrochloric acid, sodium citrate / hydrochloric acid, potassium dihydrogen citrate /hydrochloric acid, potassium dihydrogencitrate/ citric acid, sodium citrate / citric acid, sodium tartarate/ tartaric acid, sodium lactate/ lactic acid, sodium acetate/ acetic acid, disodium hydrogenphosphate/ citric acid and sodium chloride/ glycine / hydrochloric acid and mixtures thereof.

Further examples of suitable buffering agents are ammonium hydroxide, ethylamine, dipropylamine, triethylamine and alkanediamines such as 1,3-diaminopropane, anhydrous alkaline alkanolamines such as, mono or diethanolamine, preferably those which are completely substituted on the amine group such as dimethylaminoethanol, polyalkylene polyamines such as diethylenetriamine or a heterocyclic amine such as morpholine as well as the hydroxides of alkali metals, such as sodium and potassium hydroxide, hydroxides of alkali earth metals, such as magnesium and calcium hydroxide, basic amino acids such as L-alanine, lysine, oxylysine and

histidine and alkanolamines such as dimethylaminoethanol and aminoalkylpropanediol and mixtures thereof. Also suitable for use herein are compounds that form  $\text{HCO}_3^-$  by dissociation in water (hereinafter referred to as 'ion forming compounds'). Examples of suitable ion forming compounds are  $\text{Na}_2\text{CO}_3$ ,  $\text{NaHCO}_3$ ,  $\text{K}_2\text{CO}_3$ ,  $(\text{NH}_4)_2\text{CO}_3$ ,  $\text{NH}_4\text{HCO}_3$ ,  $\text{CaCO}_3$  and  $\text{Ca}(\text{HCO}_3)$  and mixtures thereof.

As herein before described certain alkaline buffering agents such as ammonium hydroxide and monoethylamine (MEA) can also act as hair swelling agents (HSA's).

Preferred for use as a buffering agent for the coloring compositions according to the present invention is ammonium hydroxide.

The coloring compositions according to the present invention may, as will be described later herein, be comprised of a final solution containing both peroxide and bleaching aids which have been admixed prior to application to the hair. As such the compositions according to the present invention may comprise bleaching and coloring kits of a number of separate components.

In bleaching and coloring kits comprising a portion of peroxide bleaching agent, which may be present in either solid or liquid form, such as hydrogen peroxide, a buffering agent solution is required to stabilise hydrogen peroxide. Since hydrogen peroxide is stable in the pH range from 2 to 4, it is necessary to use a buffering agent having a pH within this range. Dilute acids are suitable hydrogen peroxide buffering agents. Phosphoric acid is a preferred agent for buffering hydrogen peroxide solutions.

In bleaching and coloring kits comprising a bleaching aid (which may be in solid or liquid form) in combination with one or more coloring agents, a buffering agent capable of maintaining a solution pH in the range of from about 6 to about 12, preferably in the range of from about 8 to about 10, is preferred. Suitable buffering agents include compounds that form  $\text{HCO}_3^-$  by dissociation in water and alkalis generating substantially no irritating odor as

well as conventional alkaline buffering agents. Any alkali generating substantially no irritating odour can be used.

### Hair Coloring Agents

The compositions of the present invention include as an essential feature one or more hair coloring agents. Hair coloring agents suitable for use in the compositions of the present invention include both oxidative, non-oxidative and other dyes. Such hair coloring agents are used in combination with the bleaching systems of the present invention to formulate permanent, demi-permanent, semi-permanent or temporary hair dye compositions.

Permanent hair dye compositions as defined herein are compositions which once applied to the hair are substantially resistant to wash-out. Demi-permanent hair dye compositions as defined herein are compositions which are substantially removed from the hair after up to 24 washes.

Semi-permanent hair dye compositions as defined herein are compositions which once applied to the hair are substantially removed from the hair after up to 10 washes and temporary hair dye compositions as defined herein are compositions which once applied to the hair are substantially removed from the hair after up to 2 washes.

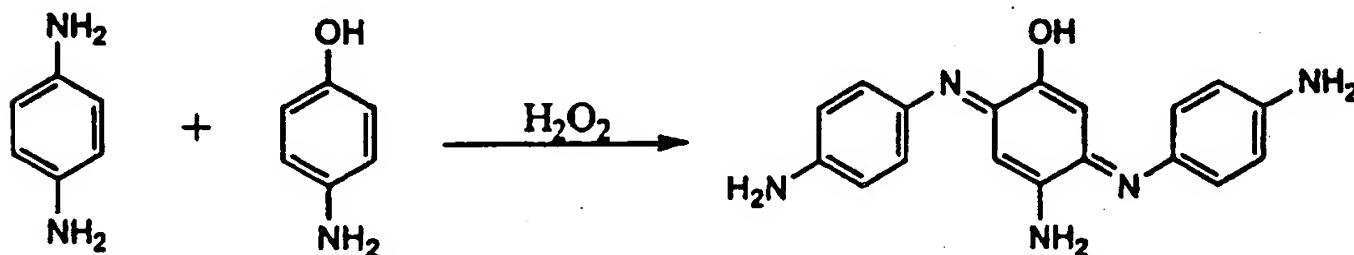
The concentration of each coloring agent in the coloring compositions according to the present invention is from about 0.001% to about 6% by weight and is preferably from about 0.01% to about 2.0% by weight.

The total combined level of coloring agents in the compositions according to the present invention is from about 0.01% to about 15%, preferably from about 0.1% to about 10%, more preferably from about 0.5% to about 5% by weight.

#### (i) Oxidative dyes

The dye forming intermediates used in oxidative dyes are essentially aromatic diamines, aminophenols and their derivatives. These dye forming intermediates can be classified as; primary and secondary intermediates and nitro dyes. Primary intermediates are chemical compounds which by themselves will form a dye upon oxidation. The secondary intermediates, also known as color modifiers or couplers and are used with other intermediates for specific color effects or to stabilise the color. Nitro dyes are unique in that they are direct dyes which do not require oxidation to dye the hair.

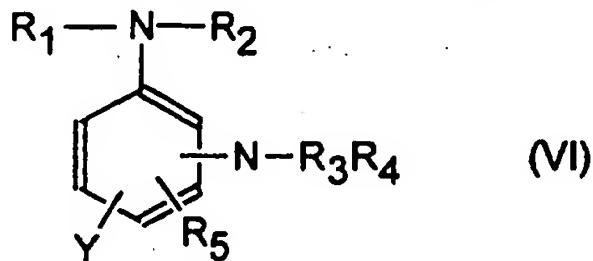
The oxidation dye intermediates which are suitable for use in the compositions and processes herein include aromatic diamines, polyhydric phenols, amino phenols and derivatives of these aromatic compounds (e.g., N-substituted derivatives of the amines, and ethers of the phenols). Primary oxidation dye intermediates are generally colorless molecules prior to oxidation. The oxidation dye color is generated when the primary intermediate is 'activated' and subsequently enjoined with a secondary intermediate (coupling agent), which is also generally colorless, to form a colored, conjugated molecule. The primary dye intermediate is generally understood to be 'activated' (oxidised) by active species liberated during the decomposition of the peroxide bleaching agent. The 'activated' dye intermediate can then react with a coupler to form a larger 'colored' dye. Oxidative dye intermediates diffuse into the hair shaft, which has been pre-swollen by action of the HSA, if present, and then are activated and coupled to form larger dye complexes within the hair shaft which are less readily washed out. An example of the peroxide activated coupling of para-aminophenol and paraphenylenediamine is illustrated below:



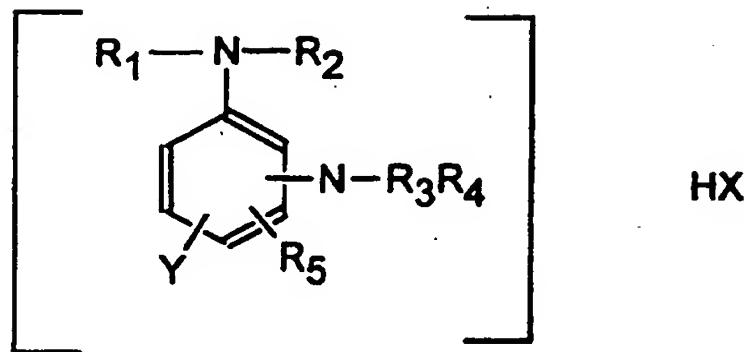
In general terms, oxidation hair dye precursors or intermediates include those monomeric materials which, on oxidation, form oligomers or polymers having extended conjugated systems of electrons in their molecular structure. Because of the new electronic structure, the resultant oligomers and polymers exhibit a shift in their electronic spectra to the visible range and appear colored. For example, oxidation dye precursors capable of forming colored polymers include materials such as aniline, which has a single functional group and which, on oxidation, forms a series of conjugated imines and quinoid dimers, trimers, etc. ranging in color from green to black. Compounds such as p-phenylenediamine, which has two functional groups, are capable of oxidative polymerization to yield higher molecular weight colored materials having extended conjugated electron systems. Color modifiers (couplers), such as those detailed hereinafter, are preferably used in conjunction with the oxidation dye precursors herein and are thought to interpose themselves in the colored polymers during their formation and to cause shifts in the electronic spectra thereof, thereby resulting in slight color changes. A representative list of oxidation dye precursors suitable for use herein is found in Sagarin, "Cosmetic Science and Technology," Interscience, Special Edn. Vol 2 pages 308 to 310. It is to be understood that the bleaching aids of the present invention are suitable for use (in combination with a source of peroxide as detailed herein) with all manner of oxidation dye precursors and color modifiers and that the precursors detailed below are only by way of example and are not intended to limit the compositions and processes herein.

The typical aromatic diamines, polyhydric phenols, amino phenols, and derivatives thereof, described above as primary dye precursors can also have additional substituents on the aromatic ring, e.g. halogen, aldehyde, carboxylic acid, nitro, sulfonic acid and substituted and unsubstituted hydrocarbon groups, as well as additional substituents on the amino nitrogen and on the phenolic oxygen, e.g. substituted and unsubstituted alkyl and aryl groups.

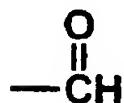
Examples of suitable aromatic diamines, amino phenols, polyhydric phenols and derivatives thereof, respectively, are compounds having the general formulas (VI), (VII) and (VIII) below:



OR



wherein Y is hydrogen, halogen, (e.g. fluorine, chlorine, bromine or iodine), nitro, amino, hydroxyl,

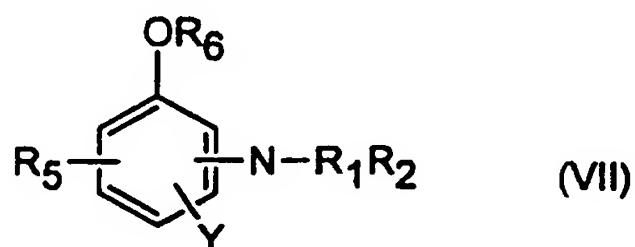


-COOM or -SO<sub>3</sub>M (where M is hydrogen or an alkali or alkaline earth metal, ammonium, or substituted ammonium wherein one or more hydrogens on the ammonium ion is replaced with a 1 to 3 carbon atom alkyl or hydroxyalkyl radical), wherein R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub> and R<sub>4</sub> are the same or different from each other and are selected from the group consisting of hydrogen, C<sub>1</sub> to C<sub>4</sub> alkyl or alkenyl and C<sub>6</sub> to C<sub>9</sub> aryl, alkaryl or aralkyl, and R<sub>5</sub> is hydrogen, C<sub>1</sub> to C<sub>4</sub>

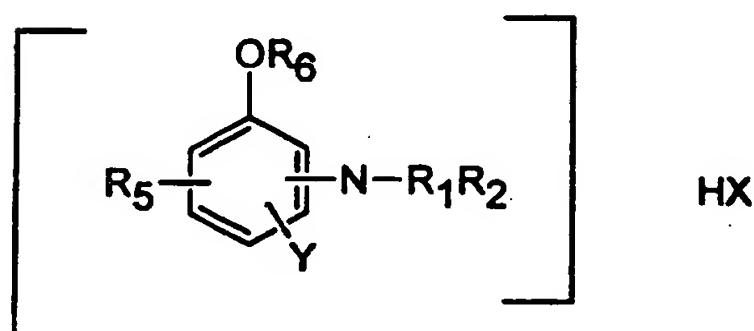
unsubstituted or substituted alkyl or alkenyl wherein the substituents are selected from those designated as Y, above, or C<sub>6</sub> to C<sub>9</sub> unsubstituted or substituted aryl, alkaryl or aralkyl wherein the substituents are selected from those defined as Y, above. Since the precursors of formula (VI) are amines, they can be used herein in the form of peroxide-compatible salts, as noted, wherein X represents peroxide-compatible anions of the type herein before detailed. The general formula of the salt indicated is to be understood to encompass those salts having mono-, di-, and tri-negative anions.

Specific examples of formula (VI) compounds are: o-phenylenediamine, m-phenylenediamine, p-phenylenediamine, 2-chloro-p-phenylenediamine, 2-iodo-p-phenylenediamine, 4-nitro-o-phenylenediamine, 2-nitro-p-phenylenediamine, 1,3,5-triaminobenzene, 2-hydroxy-p-phenylenediamine, 2,4-diaminebenzoic acid, sodium 2,4-diaminobenzoate, calcium di-2,4-diaminobenzoate, ammonium 2,4-diaminobenzoate, trimethylammonium 2,4-diaminobenzoate, tri-(2-hydroxyethyl)ammonium 2,4-diaminobenzoate, 2,4-diaminobenzaldehyde carbonate, 2,4-diaminobenzensulfonic acid, potassium 2,4-diaminobenzenesulfonate, N,N-diisopropyl-p-phenylenediamine bicarbonate, N,N-dimethyl-p-phenylenediamine, N-ethyl-N'-(2-propenyl)-p-phenylenediamine, N-phenyl-p-phenylenediamine, N-phenyl-N-benzyl-p-phenylenediamine, N-ethyl-N'-(3-ethylphenyl)-p-phenylenediamine, 2,4-toluenediamine, 2-ethyl-p-phenylenediamine, 2-(2-bromoethyl)-p-phenylenediamine, 2-phenyl-p-phenylenediamine laurate, 4-(2,5-diaminophenyl)benzaldehyde, 2-benzyl-p-phenylenediamine acetate, 2-(4-nitrobenzyl)-p-phenylenediamine, 2-(4-methylphenyl)-p-phenylenediamine, 2-(2,5-diaminophenyl)-5-methylbenzoic acid, methoxyparaphenylenediamine, dimethyl-p-phenylenediamine, 2,5-dimethylpara-phenylenediamine, 2-methyl-5-methoxy-para-phenylenediamine, 2,6-methyl-5-methoxy-para-phenylenediamine, 3-methyl-4-amino-N,N-diethylaniline, N,N-bis(β-hydroxyethyl)-para-phenylenediamine, 3-methyl-4-amino-N,N-bis(β-hydroxyethyl)aniline, 3-chloro-4-amino-N,N-bis(β-hydroxyethyl)aniline, 4-amino-N-ethyl-N-(carbamethyl)aniline, 3-methyl-4-amino-N-ethyl-N-(carbamethyl)aniline, 4-amino-N-ethyl-(β-piperidonoethyl)aniline, 3-methyl-4-amino-N-ethyl-(β-

piperidonoethyl)aniline, 4-amino-N-ethyl-N-( $\beta$ -morpholinoethyl)aniline, 3-methyl-4-amino-N-ethyl-N-( $\beta$ -morpholinoethyl)aniline, 4-amino-N-ethyl-N-( $\beta$ -acetylaminoethyl)aniline, 4-amino-N-( $\beta$ -methoxyethyl) aniline, 3-methyl-4-amino-N-ethyl-N-( $\beta$ -acetylaminoethyl) aniline, 4-amino-N-ethyl-N-( $\beta$ -mesylaminoethyl) aniline, 3-methyl-4-amino-N-ethyl-N-( $\beta$ -mesylaminoethyl) aniline, 4-amino-N-ethyl-N-( $\beta$ -sulphoethyl) aniline, 3-methyl-4-amino-N-ethyl-N-( $\beta$ -sulphoethyl) aniline, N-(4-aminophenyl)morpholine, N-(4-aminophenyl)piperidine, 2,3-dimethyl-p-phenylenediamine, isopropyl-p-phenylenediamine, N,N-bis-(2-hydroxyethyl)-p-phenylenediamine sulphate.



OR

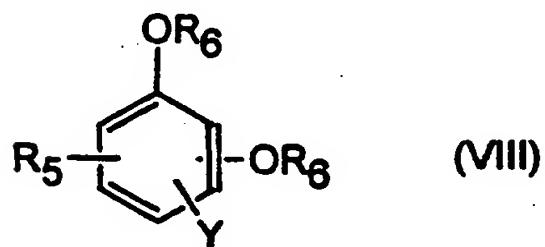


where X and Y are the same as in formula (VI), R<sub>1</sub> and R<sub>2</sub> can be the same or different from each other and are the same as in formula (VI), R<sub>5</sub> is the same as in formula (VI) and R<sub>6</sub> is hydrogen or C<sub>1</sub> to C<sub>4</sub> substituted or unsubstituted alkyl or alkenyl wherein the substituents are selected from those defined as Y in formula (VI).

Specific examples of formula (VII) compounds are:

o-aminophenol, m-aminophenol, p-aminophenol, 2-iodo-p-aminophenol, 2-nitro-p-aminophenol, 3,4-dihydroxyaniline, 3,4-diaminophenol, chloroacetate, 2-hydroxy-4-aminobenzoic acid, 2-hydroxy-4-

aminobenzaldehyde, 3-amino-4-hydroxybenzenesulfonic acid, N,N-diisopropyl-p-aminophenol, N-methyl-N-(1-propenyl)-p-aminophenol, N-phenyl-N-benzyl-p-aminophenol sulphate, N-methyl-N-(3-ethylphenyl)-p-aminophenol, 2-nitro-5-ethyl-p-aminophenol, 2-nitro-5-(2-bromoethyl)-p-aminophenol, (2-hydroxy-5-aminophenyl)acetaldehyde, 2-methyl-p-aminophenol, (2-hydroxy-5-aminophenyl)acetic acid, 3-(2-hydroxy-5-aminophenyl)-1-propene, 3-(2-hydroxy-5-aminophenyl)-2-chloro-1-propene, 2-phenyl-p-aminophenol palmitate, 2-(4-nitrophenyl)-p-aminophenol, 2-benzyl-p-aminophenol, 2-(4-chlorobenzyl-p-aminophenol perchlorate, 2-(4-methylphenyl)-p-aminophenol, 2-(2-amino-4-methylphenyl)-p-aminophenol, p-methoxyaniline, 2-bromoethyl-4-aminophenyl ether phosphate, 2-nitroethyl-4-aminophenyl ether bromide, 2-aminoethyl-4-aminophenyl ether, 2-hydroxyethyl-4-aminophenyl ether, (4-aminophenoxy)acetaldehyde, (4-aminophenoxy)acetic acid, (4-aminophenoxy)methanesulfonic acid, 1-propenyl-4-aminophenyl ether isobutyrate, (2-chloro)-1-propenyl-4-aminophenyl ether, (2-nitro)-1-propenyl-4-aminophenyl ether, (2-amino)-propenyl-4-aminophenyl ether, (2-hydroxy)-1-propenyl-4-aminophenyl ether, N-methyl-p-aminophenol, 3-methyl-4-aminophenol, 2-chloro-4-aminophenol, 3-chloro-4-aminophenol, 2,6-dimethyl-4-aminophenol, 3,5-dimethyl-4-aminophenol, 2,3-dimethyl-4-aminophenol, 2,5-dimethyl-4-aminophenol, 2-hydroxymethyl-4-aminophenol, 3-hydroxymethyl-4-aminophenol.



where Y, R<sub>5</sub> and R<sub>6</sub> are as defined above in formula (VII).

Specific examples of formula (VIII) compounds are:

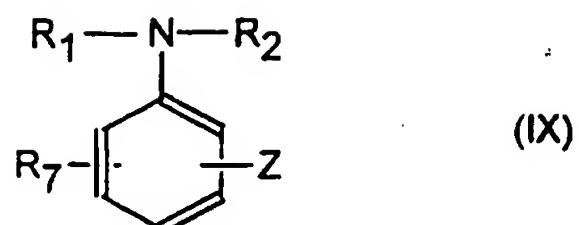
o-hydroxyphenol (catechol), m-hydroxyphenol (resorcinol), p-hydroxyphenol (hydroquinone), 4-methoxyphenol, 2-methoxyphenol, 4-(2-chloroethoxy) phenol, 4-(2-propenoxy) phenol, 4-(3-chloro-2-propenoxy) phenol, 2-chloro-4-hydroxyphenol (2-chlorohydroquinone), 2-nitro-4-hydroxyphenol(2-

nitrohydroquinone), 2-amino-4-hydroxyphenol, 1,2,3-trihydroxybenzene (pyrogallol), 2,4-dihydroxybenzaldehyde, 3,4-dihydroxybenzoic acid, 2,4-dihydroxybenzenesulfonic acid, 3-ethyl-4-hydroxyphenol, 3-(2-nitroethyl)-4-hydroxyphenol, 3-(2-propenyl)-4-hydroxyphenol, 3-(3-chloro-2-propenyl)-4-hydroxyphenol, 2-phenyl-4-hydroxyphenol, 2-(4-chlorophenyl)-4-hydroxyphenol, 2-benzyl-4-hydroxyphenol, 2-(2-nitrophenyl)-4-hydroxyphenol, 2-(2-methylphenyl)-4-hydroxyphenol, 2-(2-methyl-4-chlorophenyl)-4-hydroxyphenol, 3-methoxy-4-hydroxy-benzaldehyde, 2-methoxy-4-(1-propenyl)phenol, 4-hydroxy-3-methoxycinnamic acid, 2,5-dimethoxyaniline, 2-methylresorcinol, alpha napthol and salts thereof.

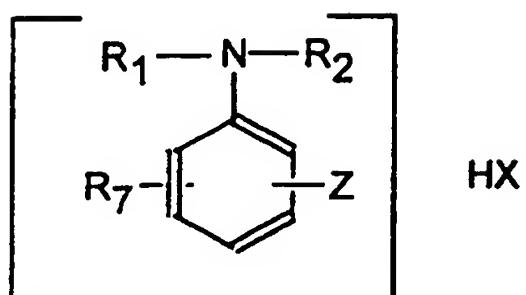
Color modifiers which are suitable for inclusion in the coloring compositions and processes herein before described include certain aromatic amines and phenols and derivatives thereof which do not produce color singly, but which modify the color, shade or intensity of the colors developed by the primary oxidized dye precursors. Certain aromatic amines and phenolic compounds, and derivatives thereof, including some aromatic diamines and polyhydric phenols of the types described by formulas (VI), (VII) and (VIII) above, but which are well known in the art not to be suitable oxidation dye precursors, are suitable as color modifiers herein. Polyhydric alcohols are also suitable for use as color modifiers.

The aromatic amines and phenols and derivatives described above as color modifiers can also have additional substituents on the aromatic ring, e.g., halogen, aldehyde, carboxylic acid, nitro, sulfonyl and substituted and unsubstituted by hydrocarbon groups, as well as additional substituents on the amino nitrogen, or phenolic oxygen, e.g. substituted and unsubstituted alkyl and aryl groups. Again, peroxide-compatible salts thereof are suitable for use herein.

Examples of aromatic amines, phenols and derivatives thereof are compounds of the general formulas (IX) and (X) below:



OR



wherein Z is hydrogen, C<sub>1</sub> and C<sub>3</sub> alkyl, halogen (e.g. fluorine, chlorine, bromine or iodine) nitro,

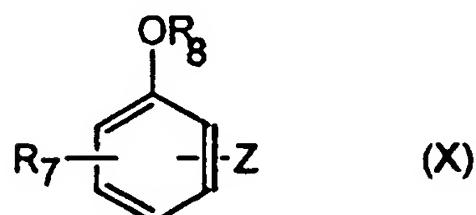


-COOM or SO<sub>3</sub>M, (where M is hydrogen or an alkali or alkaline earth metal, ammonium or substituted ammonium wherein one or more hydrogens on the ammonium ion is replaced with a 1 to 3 carbon atom alkyl or hydroxyalkyl radical), wherein R<sub>1</sub> and R<sub>2</sub> are the same or different and are selected from the group consisting of hydrogen, C<sub>1</sub> to C<sub>4</sub> alkyl or alkenyl and C<sub>6</sub> to C<sub>9</sub> aryl, alkaryl or aralkyl and R<sub>7</sub> is hydrogen, C<sub>1</sub> to C<sub>4</sub> unsubstituted or substituted alkyl or alkenyl wherein the substituents are selected from those designated as Z above or C<sub>6</sub> to C<sub>9</sub> unsubstituted or substituted aryl, alkaryl or aralkyl wherein the substituents are selected from those defined as Z above and wherein X is as defined in formula (VI).

Specific examples of formula (IX) compounds are:

aniline, p-chloroaniline, p-fluoroaniline, p-nitroaniline, p-aminobenzaldehyde, p-aminobenzoic acid, sodium-p-aminobenzoate, lithium-p-aminobenzoate, calcium di-p-aminobenzoate, ammonium-p-aminobenzoate, trimethylammonium-p-aminobenzoate, tri(2-hydroxyethyl)-p-aminobenzoate,

p-aminobenzenesulfonic acid, potassium p-aminobenzenesulfonate, N-methylaniline, N-propyl-N-phenylaniline, N-methyl-N-2-propenylaniline, N-benzyylaniline, N-(2-ethylphenyl)aniline, 4-methylaniline, 4-(2-bromoethyl)aniline, 2-(2-nitroethyl)aniline, (4-aminophenyl)acetaldehyde, (4-aminophenyl)acetic acid, 4-(2-propenyl)aniline acetate, 4-(3-bromo-2-propenyl)aniline, 4-phenylaniline chloroacetate, 4-(3-chlorophenyl)aniline, 4-benzyylaniline, 4-(4-iodobenzyl)aniline, 4-(3-ethylphenyl)aniline, 4-(2-chloro-4-ethylphenyl)aniline.



wherein Z and R<sub>7</sub> are defined as in formula (IX) and R<sub>8</sub> is hydrogen or C<sub>1</sub> to C<sub>4</sub> substituted or unsubstituted alkyl or alkenyl wherein the substituents are selected from those defined as Z in formula (IX).

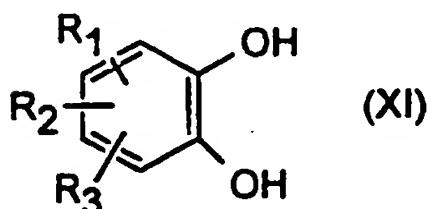
Specific examples of formula (X) compounds are:

phenol, p-chlorophenol, p-nitrophenol, p-hydroxybenzaldehyde, p-hydroxybenzoic acid, p-hydroxybenzenesulfonic acid, ethylphenyl ether, 2-chloroethylphenyl ether, 2-nitroethylphenyl ether, phenoxyacetaldehyde, phenoxyacetic acid, 3-phenoxy-1-propene, 3-phenoxy-2-nitro-1-propene, 3-phenoxy-2-bromo-1-propene, 4-propylphenol, 4-(3-bromopropyl)phenol, 2-(2-nitroethyl)phenol, (4-hydroxyphenyl)acetaldehyde, (4-hydroxyphenyl)acetic acid, 4-(2-propenyl)phenol, 4-phenylphenol, 4-benzylphenol, 4-(3-fluoro-2-propenyl)phenol, 4-(4-chlorobenzyl)phenol, 4-(3-ethylphenyl)phenol, 4-(2-chloro-3-ethylphenyl)phenol, 2,5-xylenol, 2,5-diaminopyridine, 2-hydroxy-5-aminopyridine, 2-amino-3-hydroxy pyridine, tetraaminopyrimidine, 1,2,4-trihydroxybenzene, 1,2,4-trihydroxy-5-(C<sub>1</sub>-C<sub>6</sub>-alkyl)benzene, 1,2,3-trihydroxybenzene, 4-aminoresorcinol, 1,2-dihydroxybenzene, 2-amino-1,4-dihydroxybenzene, 2-amino-4-methoxyphenol, 2,4-diaminophenol, 3-methoxy-1,2-dihydroxy-benzene, 1,4-dihydroxy-2-(N,N-diethylamino)benzene, 2,5-diamino-4-methoxy-1-

hydroxybenzene, 4,6-dimethoxy-3-amino-1-hydroxybenzene, 2,6-dimethyl-4-[N-(p-hydroxyphenyl)amino]-1-hydroxybenzene, 1,5-diamino-2-methyl-4-[N-(p-hydroxyphenyl)amino]benzene and salts thereof.

Additional oxidation dye precursors suitable for use herein include catechol species and in particular catechol "dopa" species which includes dopa itself as well as homologs, analogs and derivatives of DOPA. Examples of suitable catechol species include cysteinyl dopa, alpha alkyl dopa having 1 to 4, preferably 1 to 2 carbon atoms in the alkyl group, epinephrine and dopa alkyl esters having 1 to 6, preferably 1 to 2 carbon atoms in the alkyl group.

In general suitable catechols are represented by formula (XI) below:



wherein R<sub>1</sub>, R<sub>2</sub> and R<sub>3</sub>, which may be the same or different, are electron donor or acceptor substituents selected from H, lower (C<sub>1</sub>-C<sub>6</sub>) alkyl, OH, OR, COOR, NHCOR, CN, COOH, Halogen, NO<sub>2</sub>, CF<sub>3</sub>, SO<sub>3</sub>H or NR<sub>4</sub>R<sub>5</sub>, with the proviso that only one of the R<sub>1</sub>, R<sub>2</sub> or R<sub>3</sub> can be CN, COOH, halogen, NO<sub>2</sub>, CF<sub>3</sub> or SO<sub>3</sub>H; R<sub>4</sub> and R<sub>5</sub>, which may be the same or different, are H, lower (C<sub>1</sub>-C<sub>6</sub>) alkyl or substituted lower (C<sub>1</sub>-C<sub>6</sub>) alkyl in which the substituent may be OH, OR, NHCOR<sub>6</sub>, NHCONH<sub>2</sub>, NHCO<sub>2</sub>R<sub>6</sub>, NHCSNH<sub>2</sub>, CN, COOH, SO<sub>3</sub>H, SO<sub>2</sub>NR<sub>6</sub>, SO<sub>2</sub>R<sub>6</sub> or CO<sub>2</sub>R<sub>6</sub>; R<sub>6</sub> is lower (C<sub>1</sub>-C<sub>6</sub>) alkyl, lower (C<sub>1</sub>-C<sub>6</sub>) hydroxyalkyl phenyl linked to the nitrogen by an alkylene chain, phenyl or substituted phenyl with the substituent defined as R<sub>1</sub>, and R is C<sub>1</sub>-C<sub>6</sub> alkyl or C<sub>1</sub>-C<sub>6</sub> hydroxyalkyl.

The oxidation dye precursors can be used herein alone or in combination with other oxidation dye precursors, and one or more dye precursors can be used in combination with one or more color modifiers. The choice of a single dye precursors and modifiers will be determined by the color, shade and intensity

of coloration which is desired. There are nineteen preferred oxidation dye precursors which can be used herein, singly or in combination, to provide oxidation hair dyes having a variety of shades ranging from ash blonde to black; these are: pyrogallol, resorcinol, p-toluenediamine, p-phenylenediamine, o-phenylenediamine, m-phenylenediamine, o-aminophenol, p-aminophenol, 4-amino-2-nitrophenol, nitro-p-phenylenediamine, N-phenyl-p-phenylenediamine, m-aminophenol, 2-amino-3-hydroxypyridine, 1-naphthol, N,N bis (2-hydroxyethyl)p-phenylenediamine, 4-amino-2-hydroxytoluene, 1,5-dihydroxynaphthalene and 2,4-diaminoanisole. These can be used in the molecular form or in the form of peroxide-compatible salts, as detailed above.

## (ii) Non-oxidative dyes

Non-oxidative dyes suitable for use in the hair coloring compositions and processes according to the present invention include both semi-permanent, temporary and other dyes. Non-oxidative dyes as defined herein include the so-called 'direct action dyes', metallic dyes, metal chelate dyes, fibre reactive dyes and other synthetic and natural dyes. Various types of non-oxidative dyes are detailed in: 'Chemical and Physical Behaviour of Human Hair' 3rd Edn. by Clarence Robbins (pp250-259); 'The Chemistry and Manufacture of Cosmetics'. Volume IV. 2nd Edn. Maison G. De Navarre at chapter 45 by G.S. Kass (pp841-920); 'cosmetics: Science and Technology' 2nd Edn, Vol II Balsam Sagarin, Chapter 23 by F.E. Wall (pp 279-343); 'The Science of Hair Care' edited by C. Zviak, Chapter 7 (pp 235-261) and 'Hair Dyes', J.C. Johnson, Noyes Data Corp., Park Ridge, U.S.A. (1973), (pp 3-91 and 113-139).

Direct action dyes which do not require an oxidative effect in order to develop the color, are also designated hair tints and have long been known in the art. They are usually applied to the hair in a base matrix which includes surfactant material. Direct action dyes include nitro dyes such as the derivatives of nitroamino benzene or nitroaminophenol; disperse dyes such

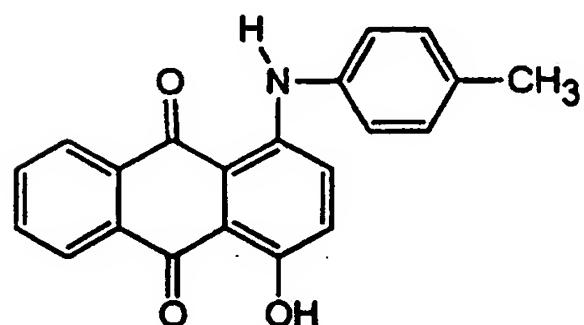
as nitroaryl amines, aminoanthraquinones or azo dyes; anthraquinone dyes, naphthoquinone dyes; basic dyes such as Acridine Orange C.I. 46005.

Further examples of direct action dyes include the Arianor dyes basic brown 17, C.I.(color index) - no. 12,251; basic red 76, C.I. - 12,245; basic brown 16, C.I. - 12,250; basic yellow 57, C.I. - 12,719 and basic blue 99, C.I. - 56,059 and further direct action dyes such as acid yellow 1, C.I. - 10,316 (D&C yellow no.7); acid yellow 9, C.I. - 13,015; basic violet C.I. - 45,170; disperse yellow 3, C.I. - 11,855; basic yellow 57, C.I. - 12,719; disperse yellow 1, C.I. - 10,345; basic violet 1, C.I. - 42,535, basic violet 3, C.I. - 42,555; greenish blue, C.I. - 42090 (FD&C Blue no.1); yellowish red, C.I.- 14700.(FD&C red no.4); yellow, C.I.19140 (FD&C yellow no5); yellowish orange, C.I.15985 (FD&C yellow no.6); bluish green, C.I.42053 (FD&C green no.3); yellowish red, C.I.16035 (FD&C red no.40); bluish green, C.I.61570 (D&C green no.3); orange, C.I.45370 (D&C orange no.5); red, C.I.15850 (D&C red no.6); bluish red, C.I.15850(D&C red no.7); slight bluish red, C.I.45380(D&C red no.22); bluish red, C.I.45410(D&C red no.28); bluish red, C.I.73360(D&C red no.30); reddish purple, C.I.17200(D&C red no.33); dirty blue red, C.I.15880(D&C red no.34); bright yellow red, C.I.12085(D&C red no.36); bright orange, C.I.15510(D&C orange no.4); greenish yellow, C.I.47005(D&C yellow no.10); bluish green, C.I.59040(D&C green no.8); bluish violet, C.I.60730(Ext. D&C violet no.2); greenish yellow, C.I.10316(Ext. D&C yellow no.7);

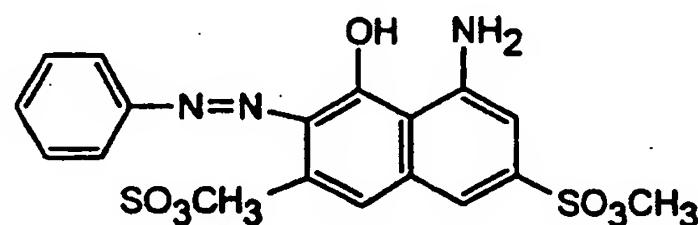
Fibre reactive dyes include the Procion (RTM), Drimarene (RTM), Cibacron (RTM), Levafix (RTM) and Remazol (RTM) dyes available from ICI, Sandoz, Ciba-Geigy, Bayer and Hoechst respectively.

Natural dyes and vegetable dyes as defined herein include henna (*Lawsonia alba*), camomile (*Matricaria chamomila* or *Anthemis nobilis*), indigo, logwood and walnut hull extract.

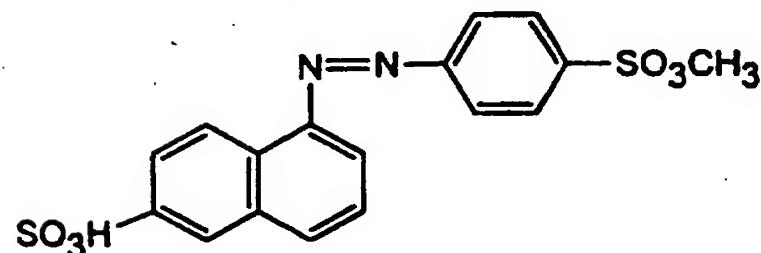
Temporary hair dyes, or hair coloring rinses, are generally comprised of dye molecules which are too large to diffuse into the hair shaft and which act on the exterior of the hair. They are usually applied via a leave-in procedure in which the dye solution is allowed to dry on the hair surface. As such these dyes are typically less resistant to the effects of washing and cleaning the hair with surface active agents and are washed off of the hair with relative ease. Any temporary hair dye may suitably be used in the compositions of the invention and examples of preferred temporary hair dyes are illustrated below.



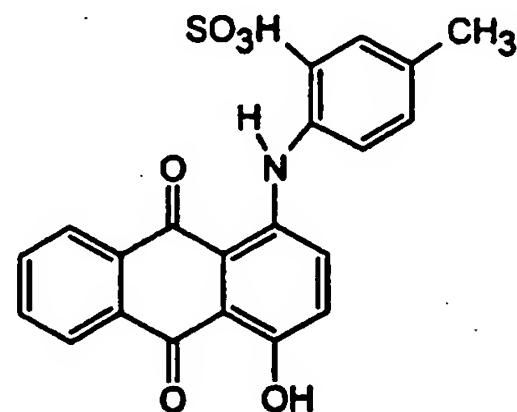
Violet



Red



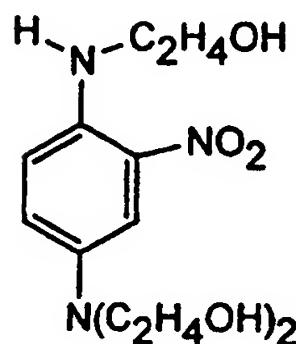
Yellow



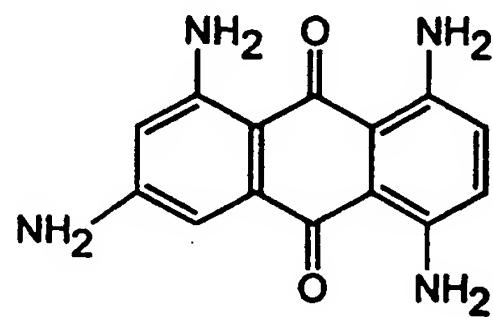
Blue-Violet

Semi-permanent hair dyes are dyes which are generally smaller in size and effect to temporary hair rinses but are generally larger than permanent (oxidative) dyes. Typically, semi-permanent dyes act in a similar manner to oxidative dyes in that they have the potential to diffuse into the hair shaft. However, semi-permanent dyes are generally smaller in size than the

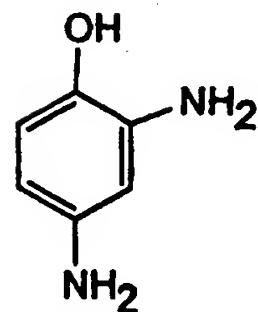
aforementioned conjugated oxidative dye molecules and as such are predisposed to gradual diffusion out of the hair again. Simple hair washing and cleaning action will encourage this process and in general semi-permanent dyes are largely washed out of the hair after about 5 to 8 washes. Any semi-permanent dye system may be suitably used in the compositions of the present invention. Suitable semi-permanent dyes for use in the compositions of the present invention are HC Blue 2, HC Yellow 4, HC Red 3, Disperse Violet 4, Disperse Black 9, HC Blue 7, HC Yellow 2, Disperse Blue 3, Disperse violet 1 and mixtures thereof. Examples of semi-permanent dyes are illustrated below:



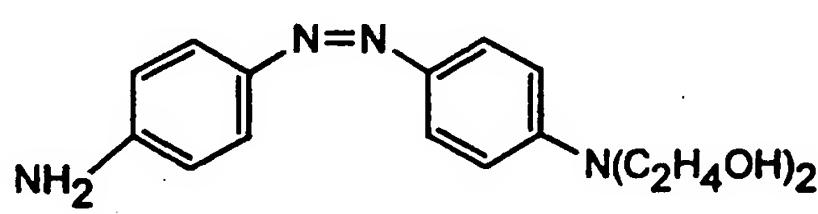
Blue



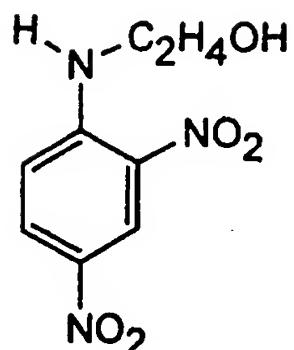
Blue



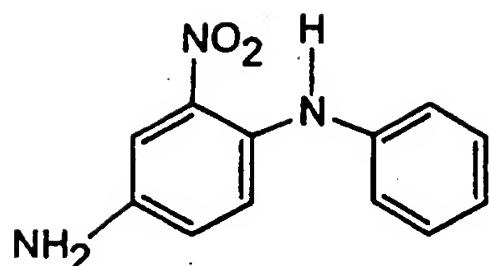
Yellow



Yellow



Red



Red

Typical semi-permanent dye systems incorporate mixtures of both large and small color molecules. As the size of the hair is not uniform from root to tip the small molecules will diffuse both at the root and tip, but will not be retained within the tip, while the larger molecules will be generally only be able to diffuse into the ends of the hair. This combination of dye molecule size is used to help give consistent color results from the root to the tip of the hair both during the initial dyeing process and during subsequent washing.

#### Bleach catalyst

The coloring compositions herein may optionally contain a transition metal containing bleach catalyst. One suitable type of bleach catalyst is a catalyst system comprising a heavy metal cation of defined bleach catalytic activity, such as copper, iron or manganese cations, an auxiliary metal cation having little or no bleach catalytic activity, such as zinc or aluminium cations, and a sequestrant having defined stability constants for the catalytic and auxiliary metal cations, particularly ethylenediaminetetraacetic acid, ethylenediaminetetra(methylenephosphonic acid) and water-soluble salts thereof. Such catalysts are disclosed in U.S. Pat. 4,430,243.

Other types of bleach catalysts include the manganese-based complexes disclosed in U.S. Pat. 5,246,621 and U.S. Pat. 5,244,594. Preferred examples of these catalysts include  $\text{Mn}^{\text{IV}}_2(\text{u-O})_3(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})_2\text{-}(\text{PF}_6)_2$ ,  $\text{Mn}^{\text{III}}_2(\text{u-O})_1(\text{u-OAc})_2(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})_2\text{-}(\text{ClO}_4)_2$ ,  $\text{Mn}^{\text{IV}}_4(\text{u-O})_6(1,4,7\text{-triazacyclononane})_4$ -

(ClO<sub>4</sub>)<sub>2</sub>, Mn<sup>III</sup>Mn<sup>IV</sup><sub>4</sub>(u-O)<sub>1</sub>(u-OAc)<sub>2</sub>-(1,4,7-trimethyl-1,4,7-triazacyclononane)<sub>2</sub>-(ClO<sub>4</sub>)<sub>3</sub>, and mixtures thereof. Others are described in EP-A-0,549,272. Other ligands suitable for use herein include 1,5,9-trimethyl-1,5,9-triazacyclododecane, 2-methyl-1,4,7-triazacyclononane, 2-methyl-1,4,7-triazacyclononane, 1,2,4,7-tetramethyl-1,4,7-triazacyclononane, and mixtures thereof.

For examples of suitable bleach catalysts see U.S. Pat. 4,246,612 and U.S. Pat. 5,227,084. See also U.S. Pat. 5,194,416 which teaches mononuclear manganese (IV) complexes such as Mn(1,4,7-trimethyl-1,4,7-triazacyclononane)(OCH<sub>3</sub>)<sub>3</sub>-(PF<sub>6</sub>). Still another type of bleach catalyst, as disclosed in U.S. Pat. 5,114,606, is a water-soluble complex of manganese (III), and/or (IV) with a ligand which is a non-carboxylate polyhydroxy compound having at least three consecutive C-OH groups. Other examples include binuclear Mn complexed with tetra-N-dentate and bi-N-dentate ligands, including N<sub>4</sub>Mn<sup>III</sup>(u-O)<sub>2</sub>Mn<sup>IV</sup>N<sub>4</sub>)<sup>+</sup> and [Bipy<sub>2</sub>Mn<sup>III</sup>(u-O)<sub>2</sub>Mn<sup>IV</sup>bipy<sub>2</sub>]- (ClO<sub>4</sub>)<sub>3</sub>.

Further suitable bleach catalysts are described, for example, in EP-A-0,408,131 (cobalt complex catalysts), EP-A-0,384,503, and EP-A-0,306,089 (metallo-porphyrin catalysts), U.S. 4,728,455 (manganese/multidentate ligand catalyst), U.S. 4,711,748 and EP-A-0,224,952, (absorbed manganese on aluminosilicate catalyst), U.S. 4,601,845 (aluminosilicate support with manganese and zinc or magnesium salt), U.S. 4,626,373 (manganese/ligand catalyst), U.S. 4,119,557 (ferric complex catalyst), DE-A-2,054,019 (cobalt chelant catalyst) CA-A-866,191 (transition metal-containing salts), U.S. 4,430,243 (chelants with manganese cations and non-catalytic metal cations), and U.S. 4,728,455 (manganese gluconate catalysts).

#### Heavy metal ion sequestrant

The coloring compositions of the invention preferably contain as an optional component a heavy metal ion sequestrant. By heavy metal ion sequestrant it is meant herein components which act to sequester (chelate or scavenge)

heavy metal ions. These components may also have calcium and magnesium chelation capacity, but preferentially they show selectivity to binding heavy metal ions such as iron, manganese and copper. Such sequestering agents are valuable in hair coloring compositions as herein described for the delivery of controlled bleaching action (as outlined in WO-A-94/03553) as well as for the provision of good storage stability of the bleaching products.

Heavy metal ion sequestrants are generally present at a level of from about 0.005% to about 20%, preferably from about 0.01% to about 10%, more preferably from about 0.05% to about 2% by weight of the compositions.

Various sequestering agents, including the amino phosphonates, available as Dequest (RTM) from Monsanto, the nitriloacetates, the hydroxyethyl-ethylene triamines and the like are known for such use. Suitable heavy metal ion sequestrants for use herein include organic phosphonates, such as the amino alkylene poly (alkylene phosphonates), alkali metal ethane 1-hydroxy disphosphonates and nitrilo trimethylene phosphonates.

Preferred among the above species are diethylene triamine penta (methylene phosphonate), ethylene diamine tri (methylene phosphonate) hexamethylene diamine tetra (methylene phosphonate) and hydroxy-ethylene 1,1 diphosphonate.

Preferred biodegradable non-phosphorous heavy metal ion sequestrants suitable for use herein include nitrilotriacetic acid and polyaminocarboxylic acids such as ethylenediaminetetraacetic acid, ethylenetriamine pentaacetic acid, ethylenediamine disuccinic acid, ethylenediamine diglutaric acid, 2-hydroxypropylenediamine disuccinic acid or any salts thereof. Especially preferred is ethylenediamine-N,N'-disuccinic acid (EDDS). see US-A-4,704,233, or the alkali metal, alkaline earth metal, ammonium, or substituted ammonium salts thereof, or mixtures thereof.

Other suitable heavy metal ion sequestrants for use herein are iminodiacetic acid derivatives such as 2-hydroxyethyl diacetic acid or glycetyl imino

diacetic acid, described in EP-A-317,542 and EP-A-399,133. The iminodiacetic acid-N-2-hydroxypropyl sulfonic acid and aspartic acid N-carboxymethyl N-2-hydroxypropyl-3-sulfonic acid sequestrants described in EP-A-516,102 are also suitable herein. The  $\beta$ -alanine-N,N'-diacetic acid, aspartic acid-N,N'-diacetic acid, aspartic acid-N-monoacetic acid and iminodisuccinic acid sequestrants described in EP-A-509,382 are also suitable.

EP-A-476,257 describes suitable amino based sequestrants. EP-A-510,331 describes suitable sequestrants derived from collagen, keratin or casein. EP-A-528,859 describes a suitable alkyl iminodiacetic acid sequestrant. Dipicolinic acid and 2-phosphonobutane-1,2,4-tricarboxylic acid are also suitable. Glycinamide-N,N'-disuccinic acid (GADS), ethylenediamine-N-N'-diglutaric acid (EDDG) and 2-hydroxypropylenediamine-N-N'-disuccinic acid (HPDDS) are also suitable.

The heavy metal ion sequestering agents of the present invention may be used in their alkali or alkaline earth metal salts.

### Thickeners

The coloring compositions of the present invention may additionally include a thickener at a level of from about 0.05% to about 20%, preferably from about 0.1% to about 10%, more preferably from about 0.5% to about 5% by weight. Thickening agents suitable for use in the compositions herein are selected from oleic acid, cetyl alcohol, oleyl alcohol, sodium chloride, cetearyl alcohol, stearyl alcohol, synthetic thickeners such as Carbopol, Aculyn and Acrosyl and mixtures thereof. Preferred thickeners for use herein are Aculyn 22 (RTM), steareth-20 methacrylate copolymer; Aculyn 44 (RTM), polyurethane resin and Acusol 830 (RTM), acrylates copolymer which are available from Rohm and Haas, Philadelphia, PA, USA. Additional thickening agents suitable for use herein include sodium alginate or gum arabic, or cellulose derivatives, such as methyl cellulose or the sodium salt of carboxymethylcellulose or acrylic polymers.

### Solvents

Water is the preferred principal diluent for the compositions according to the present invention. As such, the compositions according to the present invention may include one or more solvents as additional diluent materials. Generally, the solvent is selected to be miscible with water and innocuous to the skin. Solvents suitable for use herein include C<sub>1</sub>-C<sub>20</sub> mono- or polyhydric alcohols and their ethers, glycerine, with monohydric and dihydric alcohols and their ethers preferred. In these compounds, alcoholic residues containing 2 to 10 carbon atoms are preferred. Thus, a particularly preferred group includes ethanol, isopropanol, n-propanol, butanol, propylene glycol, ethylene glycol monoethyl ether, and mixtures thereof.

### Enzyme

A further additional material useful in the hair coloring compositions according to the present invention is one or more enzymes.

Suitable enzymatic materials include the commercially available lipases, cutinases, amylases, neutral and alkaline proteases, esterases, cellulases, pectinases, lactases and peroxidases conventionally incorporated into detergent compositions. Suitable enzymes are discussed in US Patents 3,519,570 and 3,533,139 incorporated herein by reference.

Peroxidases are haemoproteins specific for peroxide, but using a wide range of substances as donors. Catalase which decomposes peroxide, is included here in view of the fact that it is generally similar in structure and properties and is able to bring about certain oxidations by H<sub>2</sub>O<sub>2</sub>. The decomposition of H<sub>2</sub>O<sub>2</sub> can be regarded as the oxidation of one molecule by the other. It is widespread in aerobic cells and may have some more important function. The coenzyme peroxidases are not haemoproteins and one at least is a flavoprotein. Other flavoproteins such as xanthine oxidase will also use

$H_2O_2$  among other acceptors, and the coenzyme peroxidases resemble these rather than the classical peroxidases in not being specific for  $H_2O_2$ . Suitable peroxidases for the compositions of the present invention include horseradish peroxidase, Japanese radish peroxidase, cow's milk peroxidase, rat liver peroxidase, liginase and haloperoxidase such as chloro- and bromoperoxidase.

Enzymes are optionally incorporated at levels sufficient to provide up to about 50 mg by weight, more typically about 0.01mg to about 10 mg of active enzyme per gramm of the hair treatment composition of the invention. Stated otherwise the peroxidase enzyme may be incorporated into the compositions in accordance with the invention at a level of from about 0.0001% to about 5%, preferably from about 0.001% to about 1%, more preferably from about 0.01% to about 1% active enzyme by weight of the composition.

Commercially available protease enzymes include those sold under the trade names Alcalase, Savinase, Primase, Durazym, and Esperase by Novo Industries A/S (Denmark), those sold under the tradename Maxatase, Maxacal and Maxapem by Gist-Brocades, those sold by Genencor International, and those sold under the tradename Opticlean and Optimase by Solvay Enzymes. Protease enzyme may be incorporated into the compositions in accordance with the invention at a level of from 0.0001% to 4% active enzyme by weight of the composition.

Amylases include, for example,  $\alpha$ -amylases obtained from a special strain of *B. licheniformis*, described in more detail in GB-1,269,839 (Novo). Preferred commercially available amylases include for example, those sold under the tradename Rapidase by Gist-Brocades, and those sold under the tradename Termamyl and BAN by Novo Industries A/S. Amylase enzyme may be incorporated into the composition in accordance with the invention at a level of from 0.0001% to 2% active enzyme by weight of the composition.

Lipolytic enzyme may be present at levels of active lipolytic enzyme of from 0.0001% to 2% by weight, preferably 0.001% to 1% by weight, most preferably from 0.001% to 0.5% by weight of the compositions.

The lipase may be fungal or bacterial in origin being obtained, for example, from a lipase producing strain of Humicola sp., Thermomyces sp. or Pseudomonas sp. including Pseudomonas pseudoalcaligenes or Pseudomas fluorescens. Lipase from chemically or genetically modified mutants of these strains are also useful herein. A preferred lipase is derived from Pseudomonas pseudoalcaligenes, which is described in Granted European Patent, EP-B-0218272.

Another preferred lipase herein is obtained by cloning the gene from Humicola lanuginosa and expressing the gene in Aspergillus oryza, as host, as described in European Patent Application, EP-A-0258 068, which is commercially available from Novo Industri A/S, Bagsvaerd, Denmark, under the trade name Lipolase. This lipase is also described in U.S. Patent 4,810,414, Huge-Jensen et al, issued March 7, 1989.

#### Surfactant Materials

The compositions of the present invention can additionally contain a surfactant system. Suitable surfactants for inclusion in the compositions of the invention generally have a lipophilic chain length of from about 8 to about 22 carbon atoms and can be selected from anionic, cationic, nonionic, amphoteric, zwitterionic surfactants and mixtures thereof.

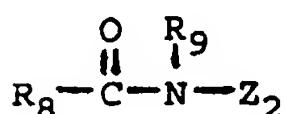
##### (i) Anionic Surfactants

Anionic surfactants suitable for inclusion in the compositions of the invention include alkyl sulphates, ethoxylated alkyl sulphates, alkyl glyceryl ether sulfonates, methyl acyl taurates, fatty acyl glycinate, N-acyl glutamates, acyl isethionates, alkyl sulfosuccinates, alkyl ethoxysulphosuccinates, alpha-sulfonated fatty acids, their salts and/or their esters, alkyl ethoxy carboxylates, alkyl phosphate esters, ethoxylated alkyl phosphate esters, alkyl sulphates, acyl sarcosinates and fatty acid/protein condensates, and mixtures

thereof. Alkyl and/or acyl chain lengths for these surfactants are C<sub>12</sub>-C<sub>22</sub>, preferably C<sub>12</sub>-C<sub>18</sub> more preferably C<sub>12</sub>-C<sub>14</sub>.

### (ii) Nonionic Surfactants

The compositions of the invention can also comprise a water-soluble nonionic surfactants. Surfactants of this class include C<sub>12</sub>-C<sub>14</sub> fatty acid mono-and diethanolamides, sucrose polyester surfactants and polyhydroxy fatty acid amide surfactants having the general formula below.

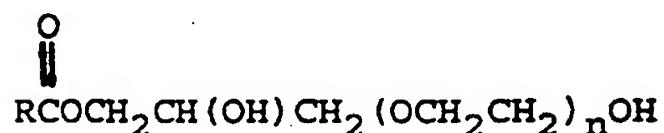


The preferred N-alkyl, N-alkoxy or N-aryloxy, polyhydroxy fatty acid amide surfactants according to the above formula are those in which R<sub>8</sub> is C<sub>5</sub>-C<sub>31</sub> hydrocarbyl, preferably C<sub>6</sub>-C<sub>19</sub> hydrocarbyl, including straight-chain and branched chain alkyl and alkenyl, or mixtures thereof and R<sub>9</sub> is typically C<sub>1</sub>-C<sub>8</sub> alkyl or hydroxyalkyl, preferably methyl, or a group of formula -R<sup>1</sup>-O-R<sup>2</sup> wherein R<sup>1</sup> is C<sub>2</sub>-C<sub>8</sub> hydrocarbyl including straight-chain, branched-chain and cyclic (including aryl), and is preferably C<sub>2</sub>-C<sub>4</sub> alkylene, R<sup>2</sup> is C<sub>1</sub>-C<sub>8</sub> straight-chain, branched-chain and cyclic hydrocarbyl including aryl and oxyhydrocarbyl, and is preferably C<sub>1</sub>-C<sub>4</sub> alkyl, especially methyl, or phenyl. Z<sub>2</sub> is a polyhydroxyhydrocarbyl moiety having a linear hydrocarbyl chain with at least 2 (in the case of glyceraldehyde) or at least 3 hydroxyls (in the case of other reducing sugars) directly connected to the chain, or an alkoxyLATED derivative (preferably ethoxylated or propoxylated) thereof. Z<sub>2</sub> preferably will be derived from a reducing sugar in a reductive amination reaction, most preferably Z<sub>2</sub> is a glycetyl moiety. Suitable reducing sugars include glucose, fructose, maltose, lactose, galactose, mannose, and xylose, as well as glyceraldehyde. As raw materials, high dextrose corn syrup, high fructose corn syrup, and high maltose corn syrup can be utilised as well as the individual sugars listed above. These corn syrups may yield a mix of sugar components for Z<sub>2</sub>. It should be understood that it is by no means intended to exclude other suitable raw materials. Z<sub>2</sub> preferably will be selected from the group consisting of -CH<sub>2</sub>-(CHOH)<sub>n</sub>-CH<sub>2</sub>OH, -CH(CH<sub>2</sub>OH)-(CHOH)<sub>n-1</sub>-

$\text{CH}_2\text{H}$ ,  $\text{CH}_2(\text{CHOH})_2(\text{CHOR}')\text{CHOH}-\text{CH}_2\text{OH}$ , where n is an integer from 1 to 5, inclusive, and R' is H or a cyclic mono- or polysaccharide, and alkoxylated derivatives thereof. As noted, most preferred are glycityls wherein n is 4, particularly  $-\text{CH}_2-(\text{CHOH})_4-\text{CH}_2\text{OH}$ .

The most preferred polyhydroxy fatty acid amide has the formula  $\text{R}_8(\text{CO})\text{N}(\text{CH}_3)\text{CH}_2(\text{CHOH})_4\text{CH}_2\text{OH}$  wherein  $\text{R}_8$  is a C6-C19 straight chain alkyl or alkenyl group. In compounds of the above formula,  $\text{R}_8\text{-CO-N}<$  can be, for example, cocoamide, stearamide, oleamide, lauramide, myristamide, capricamide, palmamide, tallowamide, etc.

Suitable oil derived nonionic surfactants for use herein include water soluble vegetable and animal-derived emollients such as triglycerides with a polyethyleneglycol chain inserted; ethoxylated mono and di-glycerides, polyethoxylated lanolins and ethoxylated butter derivatives. One preferred class of oil-derived nonionic surfactants for use herein have the general formula below:



wherein n is from about 5 to about 200, preferably from about 20 to about 100, more preferably from about 30 to about 85, and wherein R comprises an aliphatic radical having on average from about 5 to 20 carbon atoms, preferably from about 7 to 18 carbon atoms.

Suitable ethoxylated oils and fats of this class include polyethyleneglycol derivatives of glycetyl cocoate, glycetyl caproate, glycetyl caprylate, glycetyl tallowate, glycetyl palmitate, glycetyl stearate, glycetyl laurate, glycetyl oleate, glycetyl ricinoleate, and glycetyl fatty esters derived from triglycerides, such as palm oil, almond oil, and corn oil, preferably glycetyl tallowate and glycetyl cocoate.

Preferred for use herein are polyethyleneglycol based polyethoxylated C<sub>9</sub>-C<sub>15</sub> fatty alcohol nonionic surfactants containing an average of from about 5 to about 50 ethyleneoxy moieties per mole of surfactant,

Suitable polyethylene glycol based polyethoxylated C<sub>9</sub>-C<sub>15</sub> fatty alcohols suitable for use herein include C<sub>9</sub>-C<sub>11</sub> Pareth-3, C<sub>9</sub>-C<sub>11</sub> Pareth-4, C<sub>9</sub>-C<sub>11</sub> Pareth-5, C<sub>9</sub>-C<sub>11</sub> Pareth-6, C<sub>9</sub>-C<sub>11</sub> Pareth-7, C<sub>9</sub>-C<sub>11</sub> Pareth-8, C<sub>11</sub>-C<sub>15</sub> Pareth-3, C<sub>11</sub>-C<sub>15</sub> Pareth-4, C<sub>11</sub>-C<sub>15</sub> Pareth-5, C<sub>11</sub>-C<sub>15</sub> Pareth-6, C<sub>11</sub>-C<sub>15</sub> Pareth-7, C<sub>11</sub>-C<sub>15</sub> Pareth-8, C<sub>11</sub>-C<sub>15</sub> Pareth-9, C<sub>11</sub>-C<sub>15</sub> Pareth-10, C<sub>11</sub>-C<sub>15</sub> Pareth-11, C<sub>11</sub>-C<sub>15</sub> Pareth-12, C<sub>11</sub>-C<sub>15</sub> Pareth-13 and C<sub>11</sub>-C<sub>15</sub> Pareth-14. PEG 40 hydrogenated castor oil is commercially available under the tradename Cremophor (RTM) from BASF. PEG 7 glyceryl cocoate and PEG 20 glyceryl laurate are commercially available from Henkel under the tradenames Cetiol (RTM) HE and Lamacit (RTM) GML 20 respectively. C<sub>9</sub>-C<sub>11</sub> Pareth-8 is commercially available from Shell Ltd under the tradename Dobanol (RTM) 91-8. Particulary preferred for use herein are polyethylene glycol ethers of cetyl alcohol such as Ceteareth 25 which is available from BASF under the trade name Cremaphor A25.

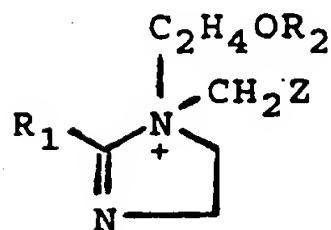
Also suitable for use herein are nonionic surfactants derived from composite vegetable fats extracted from the fruit of the Shea Tree (*Butyrospermum Karkii Kotschy*) and derivatives thereof. Similarly, ethoxylated derivatives of Mango, Cocoa and Illipe butter may be used in compositions according to the invention. Although these are classified as ethoxylated nonionic surfactants it is understood that a certain proportion may remain as non-ethoxylated vegetable oil or fat.

Other suitable oil-derived nonionic surfactants include ethoxylated derivatives of almond oil, peanut oil, rice bran oil, wheat germ oil, linseed oil, jojoba oil, oil of apricot pits, walnuts, palm nuts, pistachio nuts, sesame seeds, rapeseed, cade oil, corn oil, peach pit oil, poppyseed oil, pine oil, castor oil, soybean oil, avocado oil, safflower oil, coconut oil, hazelnut oil, olive oil, grapeseed oil, and sunflower seed oil.

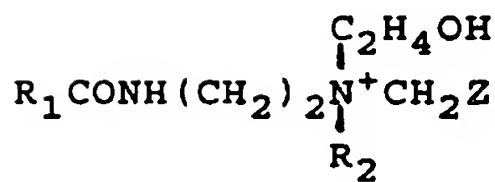
**(iii) Amphoteric Surfactants**

Amphoteric surfactants suitable for use in the compositions of the invention include:

**(a) imidazolinium surfactants of formula (XII)**



wherein R<sub>1</sub> is C<sub>7</sub>-C<sub>22</sub> alkyl or alkenyl, R<sub>2</sub> is hydrogen or CH<sub>2</sub>Z, each Z is independently CO<sub>2</sub>M or CH<sub>2</sub>CO<sub>2</sub>M, and M is H, alkali metal, alkaline earth metal, ammonium or alkanolammonium; and/or ammonium derivatives of formula (XIII)

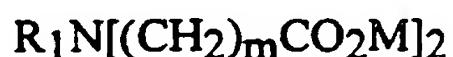


wherein R<sub>1</sub>, R<sub>2</sub> and Z are as defined above;

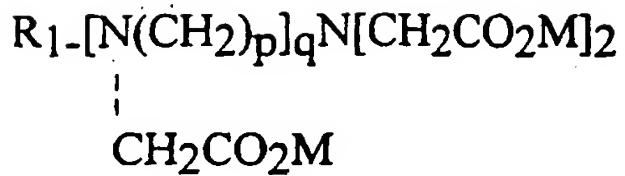
**(b) aminoalkanoates of formula (XIV)**



iminodialkanoates of formula (XV)



and iminopolyalkanoates of formula (XVI)



wherein n, m, p, and q are numbers from 1 to 4, and R<sub>1</sub> and M are independently selected from the groups specified above; and

(c) mixtures thereof.

Suitable amphoteric surfactants of type (a) are marketed under the trade name Miranol and Empigen and are understood to comprise a complex mixture of species. Traditionally, the Miranols have been described as having the general formula (XII), although the CTFA Cosmetic Ingredient Dictionary, 3rd Edition indicates the non-cyclic structure (XIII) while the 4th Edition indicates yet another structural isomer in which R<sub>2</sub> is O-linked rather than N-linked. In practice, a complex mixture of cyclic and non-cyclic species is likely to exist and both definitions are given here for sake of completeness. Preferred for use herein, however, are the non-cyclic species.

Examples of suitable amphoteric surfactants of type (a) include compounds of formula XII and/or XIII in which R<sub>1</sub> is C<sub>8</sub>H<sub>17</sub> (especially iso-capryl), C<sub>9</sub>H<sub>19</sub> and C<sub>11</sub>H<sub>23</sub> alkyl. Especially preferred are the compounds in which R<sub>1</sub> is C<sub>9</sub>H<sub>19</sub>, Z is CO<sub>2</sub>M and R<sub>2</sub> is H; the compounds in which R<sub>1</sub> is C<sub>11</sub>H<sub>23</sub>, Z is CO<sub>2</sub>M and R<sub>2</sub> is CH<sub>2</sub>CO<sub>2</sub>M; and the compounds in which R<sub>1</sub> is C<sub>11</sub>H<sub>23</sub>, Z is CO<sub>2</sub>M and R<sub>2</sub> is H.

In CTFA nomenclature, materials suitable for use in the present invention include cocoamphocarboxypropionate, cocoamphocarboxy propionic acid, and especially cocoamphoacetate and cocoamphodiacetate (otherwise referred to as cocoamphocarboxyglycinate). Specific commercial products include those sold under the trade names of Ampholak 7TX (sodium carboxy methyl tallow polypropyl amine), Empigen CDL60 and CDR 60 (Albright & Wilson), Miranol H2M Conc. Miranol C2M Conc. N.P., Miranol C2M Conc. O.P., Miranol C2M SF, Miranol CM Special (Rhône-Poulenc); Alkateric

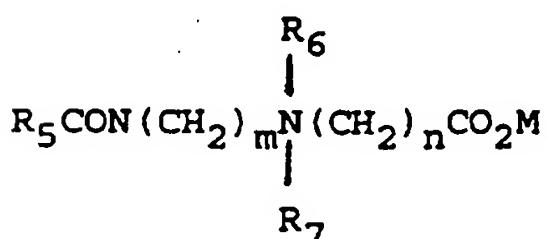
2CIB (Alkaril Chemicals); Amphoterge W-2 (Lonza, Inc.); Monateric CDX-38, Monateric CSH-32 (Mona Industries); Rewoteric AM-2C (Rewo Chemical Group); and Schercotic MS-2 (Scher Chemicals). Further examples of amphoteric surfactants suitable for use herein include Octoxynol-1 (RTM), polyoxethylene (1) octylphenyl ether; Nonoxynol-4 (RTM), polyoxyethylene (4) nonylphenyl ether and Nonoxynol-9, polyoxyethylene (9) nonylphenyl ether.

It will be understood that a number of commercially-available amphoteric surfactants of this type are manufactured and sold in the form of electroneutral complexes with, for example, hydroxide counterions or with anionic sulfate or sulfonate surfactants, especially those of the sulfated C<sub>8</sub>-C<sub>18</sub> alcohol, C<sub>8</sub>-C<sub>18</sub> ethoxylated alcohol or C<sub>8</sub>-C<sub>18</sub> acyl glyceride types. Note also that the concentrations and weight ratios of the amphoteric surfactants are based herein on the uncomplexed forms of the surfactants, any anionic surfactant counterions being considered as part of the overall anionic surfactant component content.

Examples of preferred amphoteric surfactants of type (b) include N-alkyl polytrimethylene poly-, carboxymethylamines sold under the trade names Ampholak X07 and Ampholak 7CX by Berol Nobel and also salts, especially the triethanolammonium salts and salts of N-lauryl-beta-amino propionic acid and N-lauryl-imino-dipropionic acid. Such materials are sold under the trade name Deriphat by Henkel and Mirataine by Rhône-Poulenc.

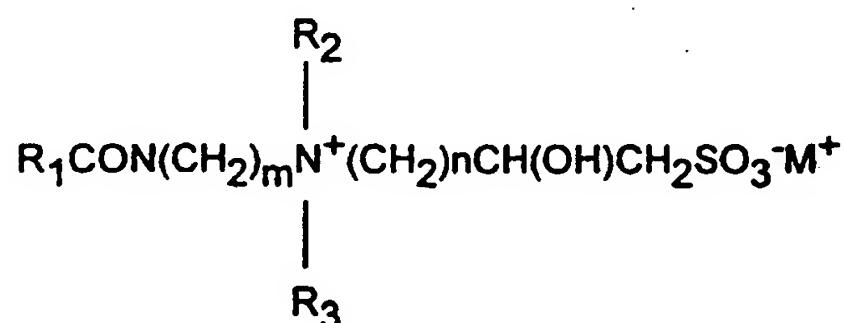
#### (iv) Zwitterionic Surfactants

Water-soluble auxiliary zwitterionic surfactants suitable for inclusion in the compositions of the present invention include alkyl betaines of the formula R<sub>5</sub>R<sub>6</sub>R<sub>7</sub>N<sup>+</sup>(CH<sub>2</sub>)<sub>n</sub>CO<sub>2</sub>M and amido betaines of the formula (XV) below:



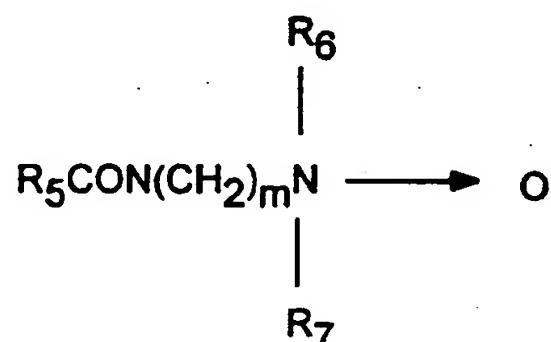
wherein R<sub>5</sub> is C<sub>11</sub>-C<sub>22</sub> alkyl or alkenyl, R<sub>6</sub> and R<sub>7</sub> are independently C<sub>1</sub>-C<sub>3</sub> alkyl, M is H, alkali metal, alkaline earth metal, ammonium or alkanolammonium, and n, m are each numbers from 1 to 4. Preferred betaines include cocoamidopropyltrimethylcarboxymethyl betaine, laurylamidopropyltrimethylcarboxymethyl betaine and Tego betaine (RTM).

Water-soluble auxiliary sultaine surfactants suitable for inclusion in the compositions of the present invention include alkyl sulfates of the formula (XVI) below:



wherein R<sub>1</sub> is C<sub>7</sub> to C<sub>22</sub> alkyl or alkenyl, R<sub>2</sub> and R<sub>3</sub> are independently C<sub>1</sub> to C<sub>3</sub> alkyl, M is H, alkali metal, alkaline earth metal, ammonium or alkanolammonium and m and n are numbers from 1 to 4. Preferred for use herein is coco amido propylhydroxy sultaine.

Water-soluble auxiliary amine oxide surfactants suitable for inclusion in the compositions of the present invention include alkyl amine oxide R<sub>5</sub>R<sub>6</sub>R<sub>7</sub>NO and amido amine oxides of the formula (XVII) below:



wherein R<sub>5</sub> is C<sub>11</sub> to C<sub>22</sub> alkyl or alkenyl, R<sub>6</sub> and R<sub>7</sub> are independently C<sub>1</sub> to C<sub>3</sub> alkyl, M is H, alkali metal, alkaline earth metal, ammonium or alkanolammonium and m is a number from 1 to 4. Preferred amine oxides include cocoamidopropylamine oxide, lauryl dimethyl amine oxide and myristyl dimethyl amine oxide.

### Optional Materials

A number of additional optional materials can be added to the coloring compositions herein described each at a level of from about 0.001% to about 5%, preferably from about 0.01% to about 3%, more preferably from about 0.05% to about 2% by weight of composition. Such materials include proteins and polypeptides and derivatives thereof; water-soluble or solubilizable preservatives such as DMDM Hydantoin, Germall 115, methyl, ethyl, propyl and butyl esters of hydroxybenzoic acid, EDTA, Euxyl (RTM) K400, natural preservatives such as benzyl alcohol, potassium sorbate and bisabolol; sodium benzoate and 2-phenoxyethanol; antioxidants such as sodium sulphite, hydroquinone, sodium bisulphite, sodium metabisulphite and thyoglycolic acid, sodium dithionite, erythrobic acid and other mercapatan; dye removers such as oxalic acid, sulphated castor oil, salicylic acid and sodium thiosulphate; H<sub>2</sub>O<sub>2</sub> stabilisers such as tin compounds such as sodium stannate, stannic hydroxide and stannous octoate, acetanilide, phenacetin colloidal silica such as magnesium silicate, oxyquinoline sulphate, sodium phosphate, and tetrasodium pyrophosphate; and p-hydroxybenzoates other moisturising agents such as hyaluronic acid, chitin, and starch-grafted sodium polyacrylates such as Sanwet (RTM) IM-1000, IM-1500 and IM-2500 available from Celanese Superabsorbent Materials, Portsmith, VA, USA and described in US-A-4,076,663; solvents; anti-bacterial agents such as Oxeco (phenoxy isopropanol); low temperature phase modifiers such as ammonium ion sources (e.g. NH<sub>4</sub> Cl); viscosity control agents such as magnesium sulfate and other electrolytes; quaternary amine compounds such as distearyl-, dilauryl-, di-hydrogenated beef tallow-, dimethyl ammonium chloride, dicetyl-diethyl ammonium methylsulphate, ditallowdimethyl ammonium methylsulphate, disoya dimethyl ammonium chloride and dicoco dimethyl ammonium chloride; enzyme stabilisers such as water soluble sources of

calcium or borate species; colouring agents; TiO<sub>2</sub> and TiO<sub>2</sub>-coated mica; perfumes and perfume solubilizers; and zeolites such as Valfour BV400 and derivatives thereof and Ca<sup>2+</sup>/Mg<sup>2+</sup> sequestrants such as polycarboxylates, amino polycarboxylates, polyphosphonates, amino polyphosphonates etc. and water softening agents such as sodium citrate. Water is also present at a level preferably of from about 2% to about 99%, preferably from about 5% to about 95%, more preferably at least from about 20 to about 92% by weight of the compositions herein.

The present invention is represented by the following non-limiting examples. In the examples, all concentrations are on a 100% active basis and all percentages are by weight unless otherwise stated and the abbreviations have the following designations:

Peroxygen bleach	hydrogen peroxide
Peroxyacid precursor 1	sodium nonanoylbenzenesulfonate (NOBS)
Peroxyacid precursor 2	acetyl triethylcitrate (ATC)
Peroxyacid precursor 3	6-nonamido caproyl oxybenzene sulphonate
Oxidative Dye 1	para-phenylene diamine
Oxidative Dye 2	para-aminophenol
Oxidative Dye 3	meta-aminophenol
Oxidative Dye 4	resorcinol
Non-oxidative Dye 1	Basic red 76

Non-oxidative Dye 2	Basic brown 16
Chelating agent	Ethylenediamine tetraaceticacid
Enzyme	Horseradish peroxidase
Surfactant 1	Nonoxynol-9
Surfactant 2	Cocoamidopropyl betaine
Surfactant 3	Sodium lauryl sulphate
Thickener	Aculyn-44

### Examples I - VI

The following are hair treatment compositions in the form of hair coloring compositions which are representative of the present invention.

In the examples, water is used as a common solvent, however water can be replaced, in part, by up to about 50% by liquids such as lower alcohols, e.g., ethylene glycol, ethylene glycol monoethyl ether, diethylene glycol, diethylene glycol monoethyl ether, propylene glycol, 1,3-propane diol, ethanol, isopropyl alcohol, glycerine, butoxyethanol, ethoxydiglycol, hexylene glycol, polyglyceryl-2-oleyl ether and mixtures thereof.

<u>Ingredient</u>	<u>I</u>	<u>II</u>	<u>III</u>	<u>IV</u>	<u>V</u>	<u>VI</u>	<u>A</u>
Peroxygen bleach	4.5	5	1	2	5	5	5
Peroxyacid precursor 1	5	5	1	1	-	-	-

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Peroxyacid precursor 2	-	-	-	-	5	-	-
Peroxyacid precursor 3	-	-	-	-	-	5	-
Oxidative Dye 1	0.8	-	0.5	0.6	0.5	0.8	0.8
Oxidative Dye 2	0.2	-	0.3	0.2	0.1	0.1	0.2
Oxidative Dye 3	1	-	0.5	1	0.6	-	1
Oxidative Dye 4	1.6	-	1.2	1.6	0.8	-	1.6
Non-Oxidative Dye 1	-	0.5	-	-	0.25	-	-
Non-Oxidative Dye 2	-	0.75	-	-	0.4	-	-
Enzyme	-	-	0.5	-	-	-	-
Surfactant 1	1	1	3	-	1	1	1
Surfactant 2	-	2	1	2	0.5	-	-
Surfactant 3	-	1	0.5	1	-	2	-
Chelating agent	0.1	0.1	0.1	0.1	0.1	0.1	0.1
Thickener	0.5	0.5	-	0.5	0.5	-	0.5
Water	..... to balance .....						

Available Oxygen Method

As herein before described the bleaching efficacy of the coloring compositions of the present invention can be described in terms of their level of 'available oxygen', also referred to as 'active oxygen (AO)'.

Peroxygen compounds contain the peroxide linkage (-O-O-) in which one of the oxygen atoms is active. This activity can be measured by the oxidation of iodide to iodine under acidic conditions or by a ceric sulphate titration. AO content, usually expressed as a percent, is the atomic weight of active oxygen divided by the molecular weight of the compound. The calculation for determining the theoretical available oxygen from any particular compound is as follows:

$$\text{AO, \%} = 100 \times (\text{no. of active oxygens}) \times (16 / \text{mol wt of compound})$$

The theoretical levels of available oxygen for peroxyacid precursors according to the present invention and conventional bleaching agents (assuming 100% perhydrolysis efficacy) are illustrated in Table I below.

Table I

<u>Material</u>	<u>% AO (theoretical)</u>
NOBS	4.7
TAED	14
ATC	5
Peracetic acid	21
Hydrogen peroxide	47
Ammonium persulphate	6.8

### Method of Manufacture

Many of the organic peroxyacids and peroxyacid precursors useful in the coloring compositions of the present invention are unstable, particularly in aqueous solution. It is therefore important to employ these solutions within a short period of time after their preparation in order to achieve the desired oxidation effect to the hair. Furthermore, it is important that the organic peroxyacid be in a form which is easy and convenient to prepare and use by the consumer, since the oxidising agent must remain in contact with the hair for a certain period of time and not run or drip off of the hair, possibly causing eye or skin irritation.

To address the above the coloring compositions of the present invention can be provided in kit form as separately packaged components to maintain stability, and, if so desired mixed by the user immediately prior to application to the hair. One component of the kit comprises an individually packaged oxidising component. Further kit components would comprise either an individually packaged bleaching aid and coloring agent mixture or two separate individual packages of bleaching aid and coloring agents. In one embodiment of the present invention the oxidising component comprises a stabilised aqueous solution of a water-soluble peroxygen bleach compound, most generally hydrogen peroxide in an amount such that the final concentration of the compound for use on the hair is from about 0.5% to about 7.5% by weight and the bleaching aid comprises an organic peroxy acid bleach precursor in an amount such that the final concentration of the compound for use on the hair is from about 0.5% to about 7.5% by weight and optionally a colorant and/or additional agents as herein before described. The compositions can either be mixed by the user immediately prior to application to the hair or can be applied separately. Examples of such kits are as follows:

- I. A hair bleaching and coloring kit is assembled comprising a single package including therein: (1) a 50 ml bottle of hydrogen peroxide (10% by weight of H<sub>2</sub>O<sub>2</sub>); and (2) a foil packet containing an organic peroxyacid bleaching precursor, such as NOBS as herein before described and optionally (3) a 50 ml bottle containing additional agents such as surfactants, antioxidants, thickeners, coloring compounds etc. The bleaching precursor is admixed with the hydrogen peroxide and the contents of the 50 ml bottle are added thereto. The resulting solution is applied to the hair and bleaches and colors it.
- II. A hair bleaching and coloring kit as described above wherein the hydrogen peroxide component is applied to the hair prior to application of the admixed contents of the bleaching precursor component and the additional agents to the hair.
- III. A hair bleaching and coloring kit as described above wherein the bleaching precursor and additional agents are admixed and applied to the hair prior to application to the hair of the hydrogen peroxide component.

#### Method of Use

The compositions herein described may be used to bleach and color hair. The coloring compositions herein are applied to the hair for periods of from 1 minute to 90 minutes depending upon the degree of coloring required. A preferred time is between 5 minutes and 30 minutes.

The products can provide excellent hair coloring and in-use efficacy benefits including reduced hair damage at lower pH.

Claims

1. A hair coloring composition comprising:
  - (a) a water-soluble peroxygen bleach;
  - (b) a bleaching aid selected from organic peroxyacid bleach precursors and/or preformed organic peroxyacids; and
  - (c) one or more hair coloring agents
2. A composition according to Claim 1 wherein the organic peroxy acid bleach precursor is selected from acetyl triethylcitrate (ATC), tetraacetyl ethylene diamine (TAED, nonanoyl oxybenzenesulphonate (NOBS), (6-octaamidocaproyl) oxybenzene sulphonate and (6-decaamidocaproyl) oxybenzene sulphate and peracetic and pernanoic acids and mixtures thereof
3. A composition according to Claim 1 or 2 wherein the weight ratio of water-soluble peroxygen bleach to bleaching aid is in the range of from about 20:1 to about 1:20, preferably from about 10:1 to about 1:10, more preferably from about 5:1 to about 1:5.
4. A composition according to any of Claims 1 to 3 wherein the molar ratio of peroxygen bleach to bleaching aid is in the range of from about 400:1 to about 1:5, preferably from about 200:1 to about 1:2, more preferably from about 3:1 to about 10:1.
5. A composition according to any of Claims 1 to 4 wherein the peroxygen bleach is present at a level of from about 0.5% to about 40%, preferably from about 1% to about 20%, more preferably from about 1.5% to about 7% by weight of the total composition.

6. A composition according to any of Claims 1 to 5 wherein the bleaching aid is present at a level of from about 0.5% to about 40%, preferably from about 1% to about 20%, more preferably from about 1.5% to about 7% by weight of the total composition.
7. A composition according to any of Claims 1 to 6 wherein the hair coloring agent is selected from oxidative and non-oxidative dyes.
8. A composition according to Claim 7 wherein each hair coloring agent is present at a level of from about 0.001% to about 6%, preferably from about 0.01% to about 2% by weight.
9. A composition according to Claim 7 wherein the total combined level of hair coloring agents from about 0.01% to about 15%, preferably from about 0.1% to about 10%, more preferably from about 0.5% to about 5% by weight.
10. A composition according to any of Claims 1 to 9 additionally comprising one or more buffering and/or hair swelling agents.
11. A composition according to Claim 10 wherein the buffering agent is selected from ammonium hydroxide, ethylamine, dipropylamine, triethylamine and alkanediamines such as 1,3-diaminopropane, anhydrous alkaline alkanolamines such as, mono or di-ethanolamine, preferably those which are completely substituted on the amine group such as dimethylaminoethanol, polyalkylene polyamines such as diethylenetriamine or a heterocyclic amine such as morpholine as well as the hydroxides of alkali metals, such as sodium and potassium hydroxide, hydroxides of alkali earth metals, such as magnesium and calcium hydroxide, basic amino acids such as L-alanine, lysine, oxylysine and histidine, alkanolamines such as dimethylaminoethanol and aminoalkylpropanediol, Na<sub>2</sub>CO<sub>3</sub>, NaHCO<sub>3</sub>, K<sub>2</sub>CO<sub>3</sub>, (NH<sub>4</sub>)<sub>2</sub>CO<sub>3</sub>, NH<sub>4</sub>HCO<sub>3</sub>, CaCO<sub>3</sub> and Ca(HCO<sub>3</sub>) and mixtures thereof.

12. A composition according to any of Claims 1 to 11 additionally comprising one or more peroxygen bleach buffering agents.
13. A composition according to Claim 12 wherein the peroxygen bleach buffering agent is a dilute acids, preferably phosphoric acid.
14. A composition according to any of Claims 1 to 13 additionally comprising one or more surfactants.
15. A composition according to Claim 14 wherein the surfactant is selected from anionic, nonionic, cationic, zwitterionic, amphoteric surfactants and mixtures thereof.
16. A composition according to any of Claims 1 to 15 additionally comprising an enzyme.
17. Use of a composition according to any of Claims 1 to 16 for coloring human or animal hair.
18. A process for coloring, human or animal hair comprising applying to the hair an organic peroxy acid precursor and/ or organic peroxy acid containing hair coloring composition which is suitable for use in contact with human skin.
19. A process according to Claim 18 for coloring human or animal hair wherein the hair coloring composition comprises:
  - (a) from about 0.5% to about 40 % by weight of a water-soluble peroxygen bleaching compound;
  - (b) from about 0.5% to about 40% by weight of an organic bleaching aid selected from organic peroxy acid bleach precursor and/or preformed organic peroxy acids;

- (c) one or more hair coloring agents, each at a level of from about 0.001% to about 6% by weight ; and
- (d) from about 20% to about 99% by weight of an inert diluent.  
wherein the coloring composition has a pH of from about 6 to about 12.

20. A hair coloring kit comprising an individually packaged oxidising component, an individually packaged bleaching aid component and an individually packaged coloring component, wherein the oxidising component comprises an aqueous solution of a water-soluble peroxygen bleaching agent at a level of from about 0.5% to about 40% by weight and the bleaching aid comprises an organic peroxy acid bleach precursor and/or organic peroxyacid at a level of from about 0.5% to about 40% by weight of the composition.

21. A hair coloring kit comprising an individually packaged oxidising component, an individually packaged mixture of bleaching aid and coloring components, wherein the oxidising component comprises an aqueous solution of a water-soluble peroxygen bleaching agent at a level of from about 0.5% to about 40% by weight and the bleaching aid comprises an organic peroxy acid bleach precursor and/or organic peroxyacid at a level of from about 0.5% to about 40% by weight of the composition.

22. Use of the hair coloring kit according to Claim 20 or 21 for the bleaching and coloring of hair wherein the bleaching aid, coloring agents and additional agents are admixed and applied to the hair prior to the application of the hydrogen peroxide component to the hair.

## INTERNATIONAL SEARCH REPORT

International application No.

PCT/US96/20170

## A. CLASSIFICATION OF SUBJECT MATTER

IPC(6) : A61K 7/13  
 US CL : 8/405, 406, 431

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 8/405, 406, 431, 107, 111; 510/186.21, 186.38, 186.41

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

HACHIK'S CHEMICAL DICTIONARY

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

Please See Extra Sheet.

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 3,861,868 A (MILBRADA et al) 21 January 1975, col. 10, lines 12-43 and col. 14, line 64-col. 15, line 4.	1-15, 17-22
Y	US 4,021,538 A (YU et al) 03 May 1977, col. 3, line 44-col. 4, line 31.	1-13, 17-22
Y	US 5,045,223 A (BATAL et al) 03 September 1991, col. 5, line 11-col. 7, line 26 and col. 9, lines 46-48.	1-22
Y	US 5,047,163 A (BATAL et al) 10 September 1991, col. 5, line 11-col. 7, line 45 and col. 10, lines 1-2.	1-22
Y	US 5,360,569 A (MADISON et al) 01 November 1994, col. 6, line 3-col. 8, line 38 and col. 10, lines 57-58.	1-22

 Further documents are listed in the continuation of Box C. See patent family annex.

• Special categories of cited documents:	
"A"	document defining the general state of the art which is not considered to be of particular relevance
"E"	earlier document published on or after the international filing date
"L"	document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reasons (as specified)
"O"	document referring to an oral disclosure, use, exhibition or other means
"P"	document published prior to the international filing date but later than the priority date claimed
T	bearer document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
X	document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
Y	document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
Z	document member of the same patent family

Date of the actual completion of the international search

11 FEBRUARY 1997

Date of mailing of the international search report

04 APR 1997

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**INTERNATIONAL SEARCH REPORT**

International application No.

PCT/US96/20170

**B. FIELDS SEARCHED**

Electronic data bases consulted (Name of data base and where practicable terms used):

**APS, DIALOG**

search terms: hair, keratin, dye, color, tint, peroxygen, peroxide, persulfate, periodate, perborate, peracid, peroxyacid, peracetic, peroxyacetic